

Date: Thursday, 11/29/2007 11:00:55 AM
 User: Kim Johnston

Process Sheet

50

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 355 SPACEPOD ASSEMBLY LH/ DSI 9335
 Job Number : 36014
 Estimate Number : 13075
 P.O. Number : N/A
 This Issue : 11/29/2007 S.O. No. : *plb*
 Prsht Rev. : NC
 First Issue : N/A Type : SMALL /MED FAB
 Previous Run : N/A
 Written By : *07.11.29*
 Checked & Approved By : *07.11.29*
 Comment : Est Rev: A 07.11.27 new issue EC

Part Number : D355600243
 Drawing Number : IIN REV.C PG11,18-21
 Project Number : N/A
 Drawing Revision : N/A
 Material : *N/A*
 Due Date : 12/12/2007 Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-600-241 CHG001

243

07/12/21

2.0 36014A SPACEPOD BODY LH (355)



Comment: Sub-Component D3188-3M
 SPACEPOD BODY LH (355)

B 36014A ml 07/12/20

3.0 36014B SPACEPOD DOOR LH



Comment: Sub-Component SPACEPOD DOOR LH

D3186-3 batch: B 36014B ml 07/12/20

AS 07/12/20 (X1)

4.0 D31871 Spacepod Floor



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3187-1

Floor

3535

AS

07/12/21

5.0 ALS41032130 Insert



Comment: Qty.: 28.0000 Each(s)/Unit Total : 28.0000 Each(s)

insert

batch:

M 05730

AS

07/12/21

(X1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/29/2007 11:00:55 AM
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Job Number: 36014

Part Number: D355600243

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	A3235020935	Washer - Countersunk
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
WASHER

M166150

7.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
1-Drill holes in D3188-1 using drill jig DT8970
2-Open holes in D3188-1 body floor to Ø0.297" as per dwg D3188
3-Deburr
4-Install inserts in D3188-1 as per Dwg D3188.

ml 07/12/20 X1

8.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

5 07/12/20 (X1)

9.0	D2986	Black Neoprene foam .125
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Comment: Qty.: 5.9010 sf(s)/Unit Total : 5.9010 sf(s)
neoprene foam
✓ batch: B30632

ml 07/12/20

10.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut D2986 Neoprene Foam per template D2986T1

ml 07/12/20

11.0	D30153	Lock Nut
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Lock Nut
batch: B35479

AS 07/12/20 (X1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 36014

Part Number: D355600243

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D35547

BALL STUD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BALL STUD

batch: B30210

JS 07/12/20 (X)

13.0

D35671

DECAL



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

DECAL

batch: 31127

JS 07/12/20 (X)

14.0

AN960JD516

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Washer

BATCH: M104156

JS 07/12/20

15.0

D2237

Striker Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Batch: B33486

JS 07/12/20 (X)

16.0

MS20426AD45

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Batch: M3459

JS 07/12/20 (X)

17.0

D35381

HINGE BRACKET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

HINGE BRACKET

batch: B35454

JS 07/12/20 YI

18.0

D2179

-Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Batch: 30030

JS 07/12/20 (X)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 36014

Part Number: D355600243

Job Number:



Seq. #:	Machine Or Operation:	Description :
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19.0	AN526C832R24	screw
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

batch: M104603

PTO
AS 07/12/21 (X)

20.0	AN960JD8	Washer
------	----------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: M105057

AS 07/12/21 (X)

21.0	MS21042L08	Nut
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

batch: M105430

AS 07/12/21 (X)

22.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

this step separates hardware, previous steps is for body & floor

1 N/A ml 07/12/20

23.0	MS270390811	Screw
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: 104427

AS 07/12/21 (X)

24.0	AN960JD8	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: M105057

AS 07/12/21 (X)

25.0	NAS1515H3	Washer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: M105164

AS 07/12/21 (X)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/12/21
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/12/21	19	Screens aren't long enough for upper holes	UE 07.12.21	Put them back in store and use 2x MS27039C0827 M106298 and 2x AN960JD8L M6956	UE 07.12.21 ml 07/12/21	↓ 07/12/21	UE 07.12.21	↓ 07/12/21

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Drawing Name: 355 SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 36014

Part Number: D355600243

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

MS21042L08

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch:

~~36681~~ M105430

JS

07/12/21 (X)

27.0

D2464

3/4 Seal



Comment: Qty.: 11.3400 f(s)/Unit Total : 11.3400 f(s)

3/4 Seal

Cut 127.00" long

batch:

30681

JS

07/12/21 (X)

28.0

D35671

DECAL



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

DECAL

batch:

31127

JS

07/12/21 (X)

29.0

D2586

Door Latch



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Door Latch

batch:

35802

JS

07/12/21 (X)

30.0

D2585

Latch Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Latch Clamp

batch:

36020

JS

07/12/21 (X)

31.0

D2621

Latch Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Latch Plate

batch:

B32355

JS

07/12/21 (X)

32.0

MS27039115

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch:

M104156

JS

07/12/21 (X)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 36014

Part Number: D355600243

Job Number:



Seq. #:	Machine Or Operation:	Description :
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33.0	AN960JD10	Washer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Washer
batch: M105792

JS 07/12/21 (X1)

34.0	MS21042L3	Nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Nut
batch: M109558

JS 07/12/21 (X1)

35.0	D28571	Hinge Bracket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Hinge Bracket
batch: 33942

JS 07/12/21 (X1)

36.0	D28572	Hinge Bracket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Hinge Bracket
batch: B33453

JS 07/12/21 (X1)

37.0	D2228	Backing Plate
------	-------	---------------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Backing Plate
batch: B30079

JS 07/12/21 (X1)

38.0	AN526C832R10	Screw
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Screw
batch: M104603

JS 07/12/21 (X1)

39.0	AN960JD8-	Washer
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Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)
Washer
batch: M105057

JS 07/12/21 (X1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: 355 SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 36014

Part Number: D355600243

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

MS21042L08

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut

batch: M105430

AS 07/12/21 (X1)

41.0

D35571

BRACKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BRACKET

batch: B32647

AS 07/12/21 (X1)

42.0

AN526C832R14

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: M9216

AS 07/12/21 (X1)

43.0

AN526C832R10

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: M104603

AS 07/12 (X1)

44.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3186-3 door with D3188-1 body as per Dwg ICA-D350-600

Hardware on previous steps is for door ass'y*

1-drill and plug section I-I and J-J of dwg D3188 p.11 using Hysol 934NA with milled glass fibres 10% to weight

A/R Hysol batch: 1105573 expire date: March 2008

A/R Milled fibres batch: M100859

X1

2-Attach Neoprene Foam using Contact Cement

A/R Contact Cement Batch: M102555

m107/12/21

45.0

QC5

INSPECT WORK TO CURRENT STEP


















Comment: INSPECT WORK TO CURRENT STEP

07/12/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/12/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-12-20	440	Upon Assembly of the D3186-3 door onto the D3188-3 body, it was noticed that the curve of the 335 at the top hinge location, the hinge did not sit flat to the body inside or out.	 07.12.20	Ins. the top. Prior to filling hole location with the hycol, remove the material until a flat equal surface is achieved, to accommodate the D2179 hinge bracket. - Fill with hycol as per drawing - apply millib. bar to smooth out surface for D2179. Per Q51037 line	 07/12/20	 7/12/21	 07.12.20	 07-12-20
			 07.12.20	outs. the top? fabricate a shim to compensate the difference between the D3538-1 bracket & 6061-T6 .250 x 1.25 M 10956 (2 pieces) per M 1105573	 07/12/21	 4/12/21	 07.12.20	 07-12-20
				* This time only & * Hycol 934NA M105573 milled fiber M100859 (15%)	 07/12/21	 4/12/21		 07-12-20

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 355 SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 36014

Part Number: D355600243

Job Number:



Seq. #:

Machine Or Operation:

Description :

46.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk Spacepod top surface of Pod as per Dwg D3188 & QSI 005 4.4

Batch: M106332

ml 07/12/21

47.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Wing Walk

M-1

07/12/21 (1X)

48.0

K10021

Spacepod Hardware Kit (-241)



Comment: Qty.: 1.0000 (s)/Unit Total : 1.0000 (s)

B36203 AS 07/12/21 (X)

49.0

D350600449

SWITCH RELOCATION KIT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SWITCH RELOCATION KIT

B32369 AS

50.0

D2985

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Label

B32470 AS 07/12/21 (X)

51.0

D35471

BRACKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BRACKET

batch:

B32372 AS 07/12/21 (X)

52.0

D35501

STRUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

STRUT

batch:

B36226 AS 07/12/21 (X)

53.0

D35527

CARBON STEEL GAS SPRING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CARBON STEEL GAS SPRING

batch:

B32044 AS 07/12/21 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Drawing Name: 355 SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 36014

Part Number: D355600243

Job Number:



Seq. #:

Machine Or Operation:

Description :

54.0

D35547

BALL STUD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
BALL STUD
batch: B 3020

AS

07/12/21 (X)

55.0

AN960JD516

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Washer
batch: M104156

AS

07/12/21 (X)

56.0

D30153

Lock Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Lock Nut
batch: B34197

AS

07/12/21 (X)

57.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

07/12/21 (X)

58.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D350-600-141
Location:
PPP Rev: Draft

07/12/20 @

59.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/12/21 (1)

Job Completion



07/12/21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

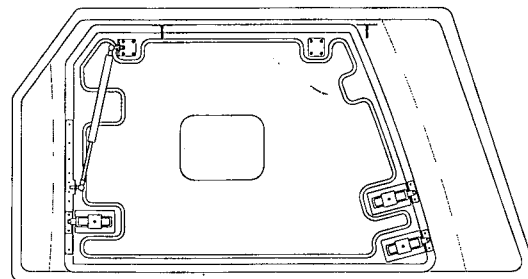
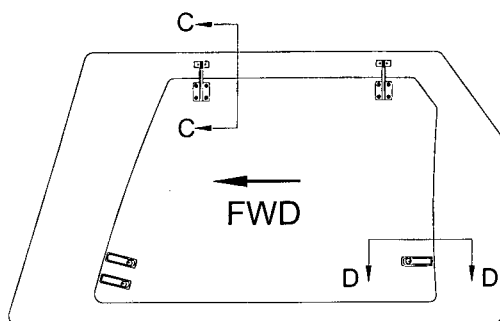


FIGURE 6(a). -141 SPACEPOD KIT (-142 OPPOSITE, -143 SIMILAR)
(OUTSIDE VIEW SHOWN ON LEFT; INSIDE VIEW SHOWN ON RIGHT)

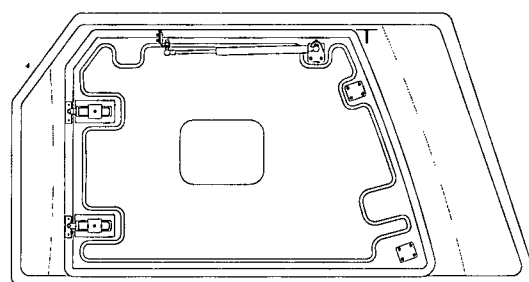
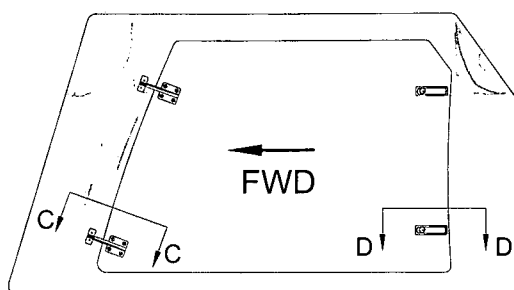
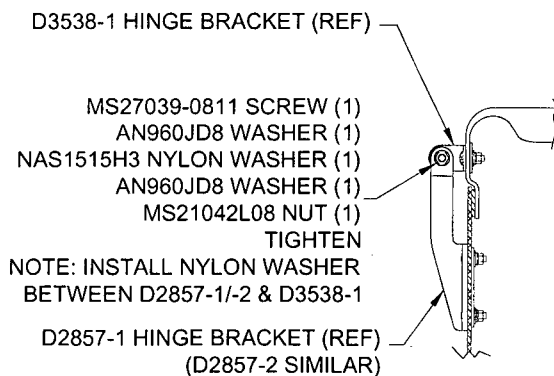
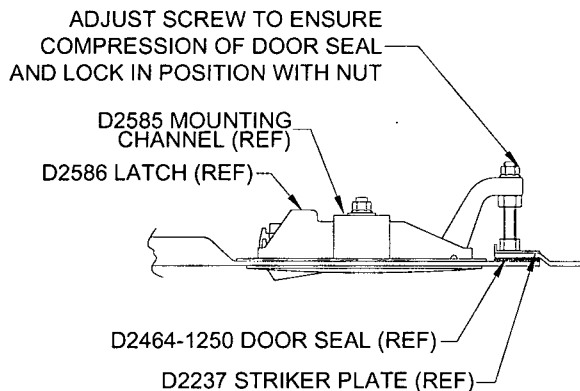


FIGURE 6(b). -241 SPACEPOD KITS (-242 OPPOSITE, -243 SIMILAR)
(OUTSIDE VIEW SHOWN ON LEFT; INSIDE VIEW SHOWN ON RIGHT)



SECTION 'C-C' HINGE
(-141 SHOWN; -142/-143/-241/-242/-243 SIMILAR)



SECTION 'D-D' LATCH

- 3.2.12 Re-install the following components that were removed from the aircraft in earlier steps:
- Re-install the battery shelf cover or wiring cover per the Aircraft Maintenance Manual necessary to trim the lower edge to clear the pod floor, touch up the paint using MIL-C-85285 polyurethane paint.
 - If applicable, re-install the pop-out float cylinders per the Aircraft Maintenance Manual.
 - Re-install the belly panel per the Aircraft Maintenance Manual.

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WITHOUT NOTICE
WORK ORDER
NO. 36014

- 3.4.5 After the paint has dried, apply the D2464-1250 neoprene seal where removed in earlier steps.
- 3.4.6 Cut out the rectangular section shown in Figures 14(a) and 14(b). Install the D2586 latch, D2588 mounting channel and D2621 latch plate that were removed earlier from the door using new hardware as shown in Figure 14(c).

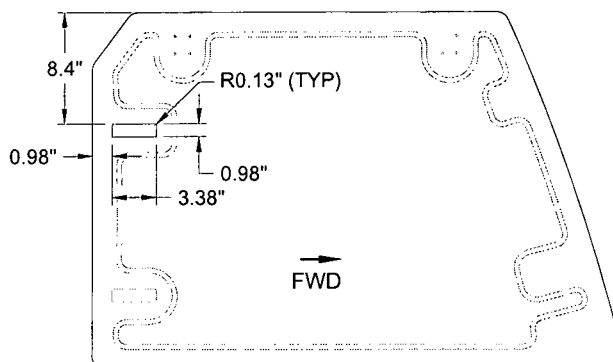


FIGURE 14(a). D3186-1 SPACEPOD DOOR LATCH CUTOUT
(APPLICABLE FOR -041/-043/-141/-143 KITS)

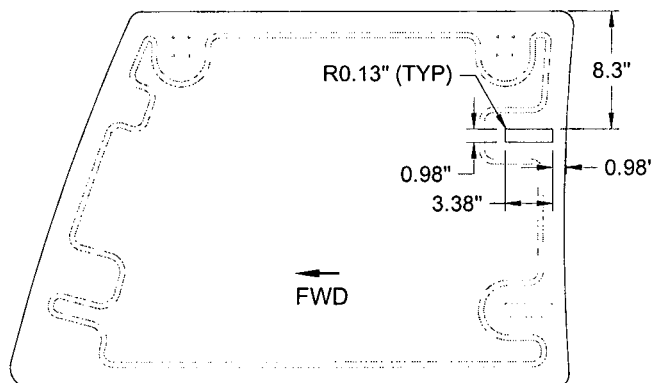


FIGURE 14(b). D3186-2 SPACEPOD DOOR LATCH CUTOUT
(APPLICABLE FOR -042/-142 KITS)

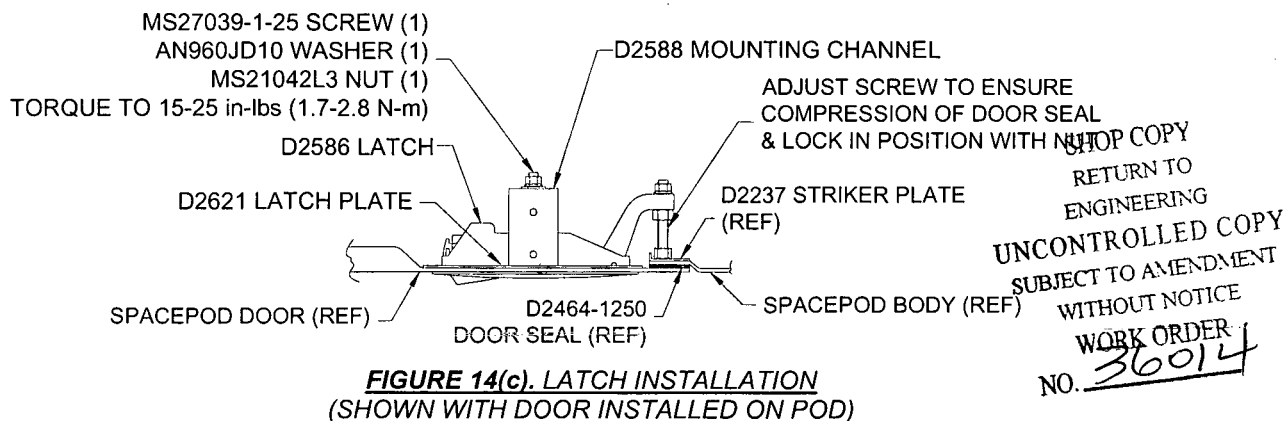


FIGURE 14(c). LATCH INSTALLATION
(SHOWN WITH DOOR INSTALLED ON POD)

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Revision: **C**

Date: 07.02.20

- 3.4.7 Position the D2857-1/2 hinge brackets as shown in Figure 15(a) for the LH side and Figure 15(b) for the RH side. Transfer drill the $\varnothing 0.172$ " mounting holes on each bracket to the **Spacepod™** door. Install the hinge brackets as shown in Section J-J.

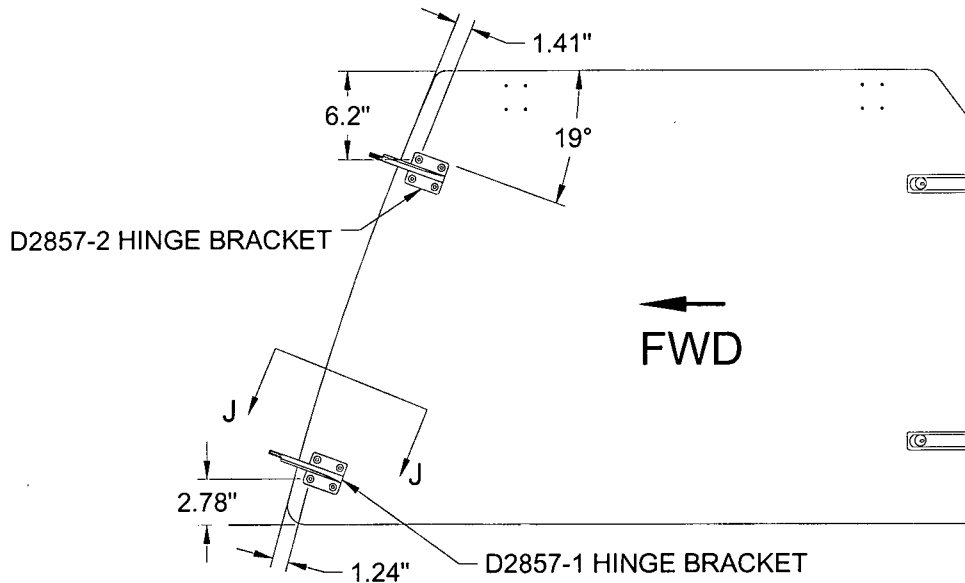


FIGURE 15(a). HINGE BRACKET POSITION ON LH D3186-1 SPACEPOD DOOR

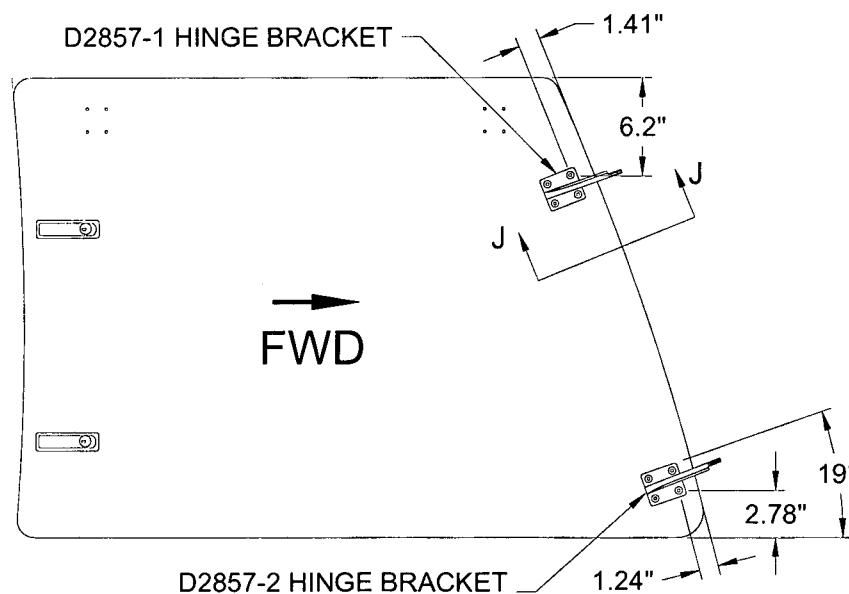
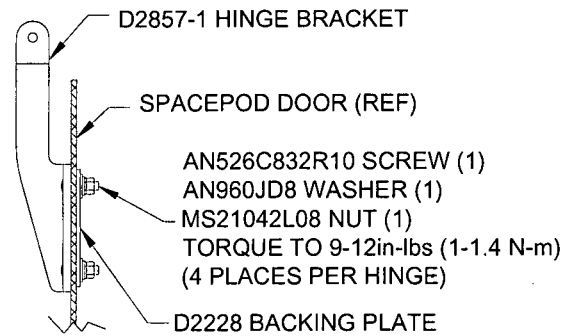


FIGURE 15(b). HINGE BRACKET POSITION ON RH D3186-2 SPACEPOD DOOR

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SECTION 'J-J' HINGE BRACKET INSTALLATION
(D2857-1 SHOWN; D2857-2 SIMILAR)

- 3.4.8 Install the D3557-1 bracket in the existing forward hinge mounting holes with the D2228 backing plates and the D3554-7 ball stud as shown in Figure 16.

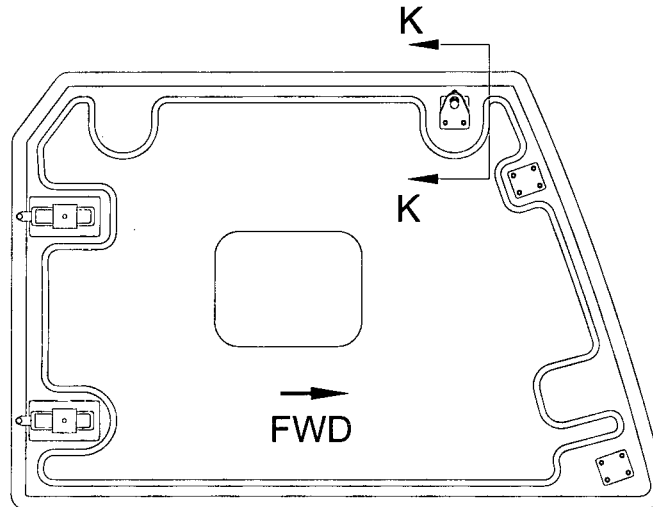
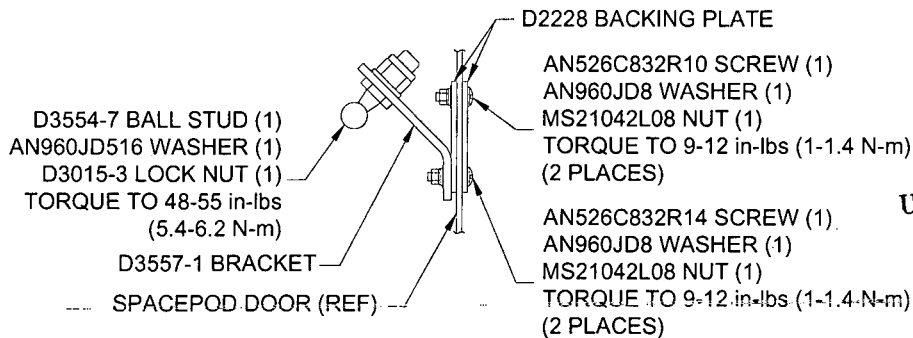


FIGURE 16. BRACKET AND BALL STUD INSTALLATION ON SPACEPOD DOOR
(INSIDE OF D3186-1 SHOWN; D3186-2 OPPOSITE)



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SECTION 'K-K'

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Revision: **C**
Date: 07.02.20

- 3.4.9 Install the hinge brackets on the pod as shown in Figures 17(a) and 17(b):
- Assemble the D3538-1 hinge brackets with the D2857-1/-2 hinge brackets as shown in Figure 17(b). Position the door on the pod and transfer mark the mounting holes from the D3538-1 hinge brackets to the **Spacepod™** body.
 - Remove the door and drill Ø0.375" holes where marked. Remove the foam inner layer 0.250" around the hole between the inner and outer skins as shown in Figure 17(a).
 - Apply tape or an equivalent backer to the inner side of the holes to prevent epoxy filler from going through. Fill the cavity between the skins completely with Hysol 934NA mixed with milled glass fibers to in a ratio of 10:1 or Metalset A4. Allow the material to cure.
 - Reposition the **Spacepod™** door and hinges and transfer drill the Ø0.172" D3538-1 hinge bracket mounting holes to the pod.
 - Install the hinge brackets and **Spacepod™** door as shown in Figure 17(b).

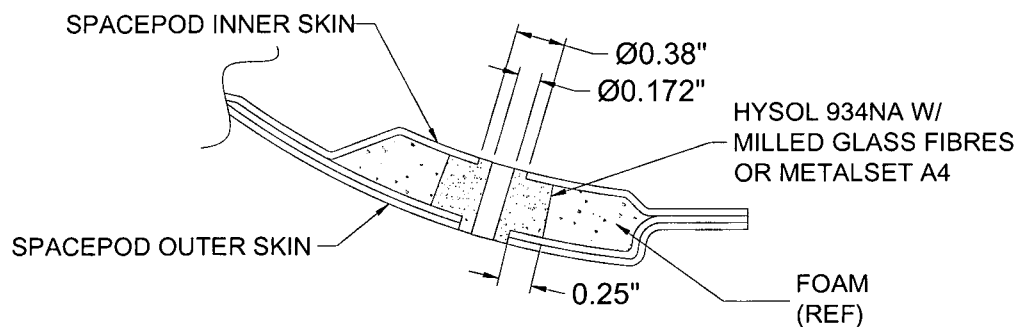


FIGURE 17(a). COMPOSITE MODIFICATION

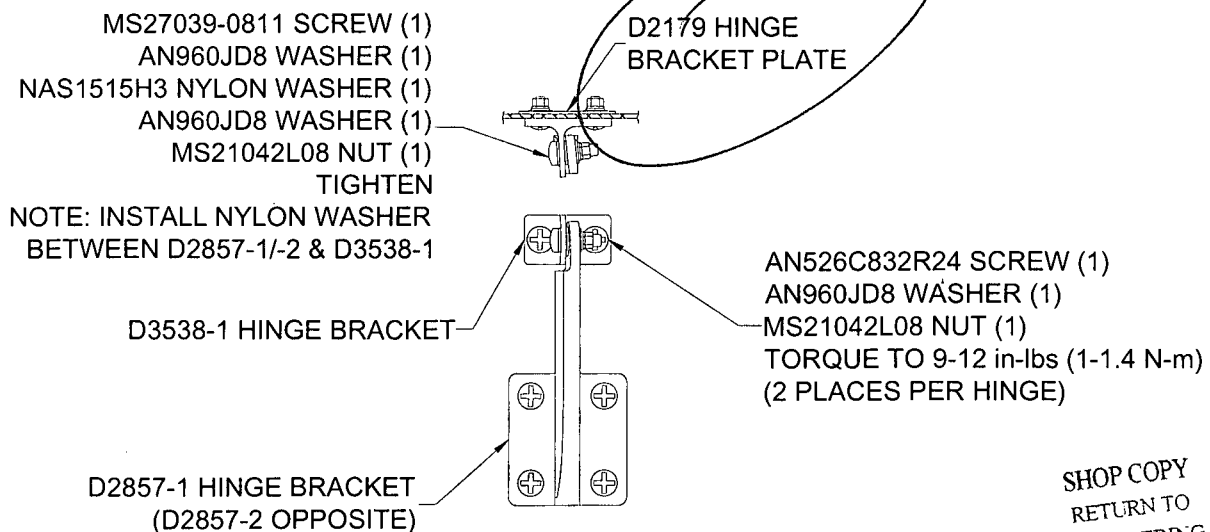


FIGURE 17(b). HINGE BRACKET INSTALLATION
(D2857-1 SHOWN; D2857-2 OPPOSITE)

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NO. 36014

Date: Thursday, 11/29/2007 11:00:55 AM
 User: Kim Johnston

Process Sheet

50

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 36014
 Estimate Number : 13075
 P.O. Number :
 This Issue : 11/29/2007 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : SMALL /MED FAB
 Previous Run :

Drawing Name : 355 SPACEPOD ASSEMBLY LH/ DSI 9335

Part Number : D355600243

Drawing Number : IIN REV.C PG11,18-21

Project Number : N/A

Drawing Revision : C

Material :

Due Date : 12/12/2007 Qty: 1 Um: Each

Written By : Kim Johnston
 Checked & Approved By : Kim Johnston
 Comment : Est Rev: A 07.11.27 new issue EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D355-600-243 CHG001

07.12.06 Kim Johnston

2.0 36014A SPACEPOD BODY LH (355)



Comment: Sub-Component D3188-3M
 SPACEPOD BODY LH (355)

3.0 36014B SPACEPOD DOOR LH



Comment: Sub-Component SPACEPOD DOOR LH
 D3186-3 batch: _____

4.0 D31871 Spacepod Floor



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3187-1 Floor _____

REFERENCE ONLY

5.0 ALS41032130 Insert



Comment: Qty.: 28.0000 Each(s)/Unit Total : 28.0000 Each(s)

insert

batch: _____

Date: Thursday, 11/29/2007 11:00:58 AM
 User: Kim Johnston

Process Sheet

50

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD DOOR LH
Job Number	: 36014B		
Estimate Number	: 12635		
P.O. Number	:	Part Number	: D31863
This Issue	: 11/29/2007 S.O. No. :	Drawing Number	: D3186 REV.D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: D
Previous Run	: 35395B	Material	:
Written By	:	Due Date	: 12/12/2007
Checked & Approved By	:	Qty:	1 Um: Each
Comment	: Est Rev:A New Issue 07-01-11 EC est rev B rev D dwg 07.03.07 ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	36014B01	SPACEPOD DOOR LH
-----	----------	------------------



Comment: Sub-Component SPACEPOD DOOR LH

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill holes and cut out latch slots per dwg D3186 (D3186-3 detail)

ml 07/12/20 x1

3.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

G 12/12/20 (H)

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

ml 07/12/20 x1

5.0	QC21	FINAL INSPECTION/W/O RELEASE
-----	------	------------------------------



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 07.12.21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

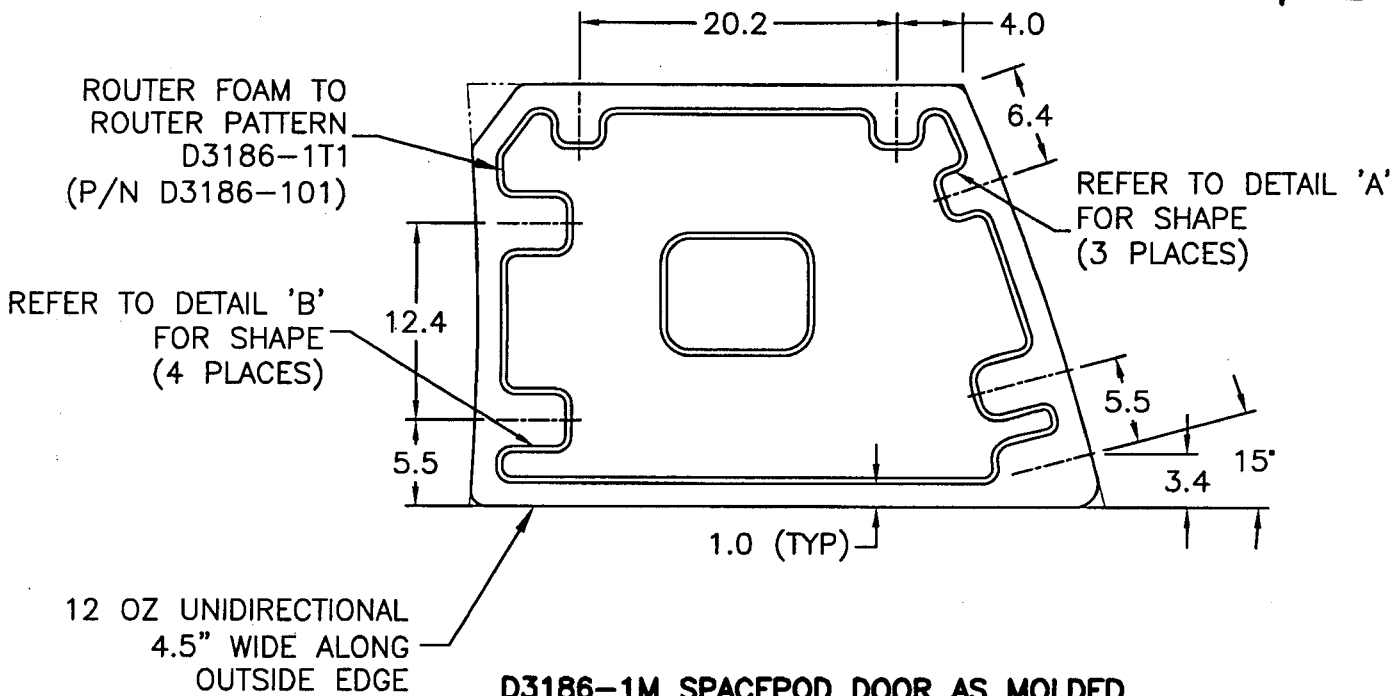
NOTE: Date & initial all entries

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DESIGN DS	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3186	REV. D SHEET 1 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS
A	03.03.27	NEW ISSUE	
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED07.02.27 *H***NOTES:**

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYLCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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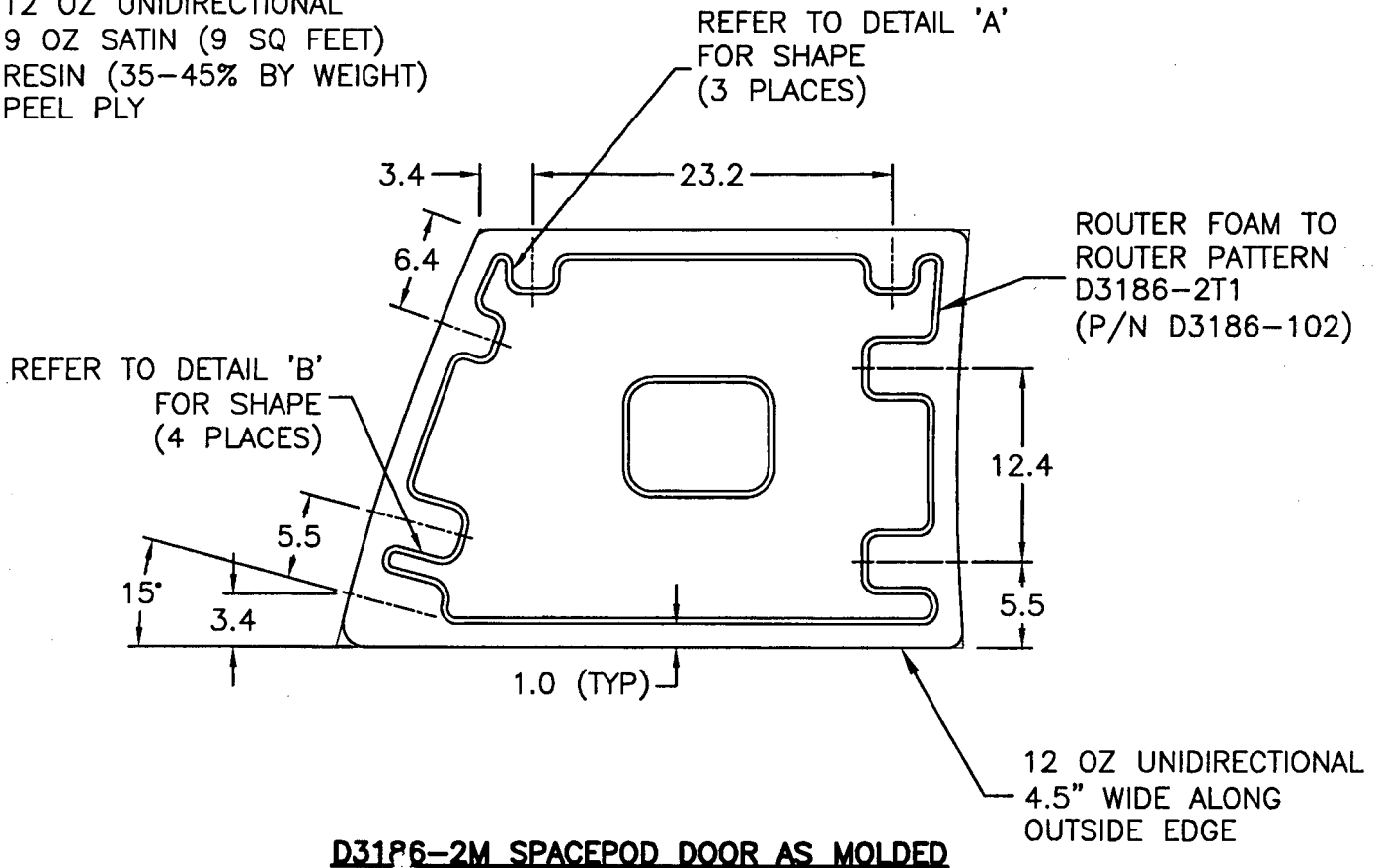
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DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED

07.02.22 H

**D3186-2M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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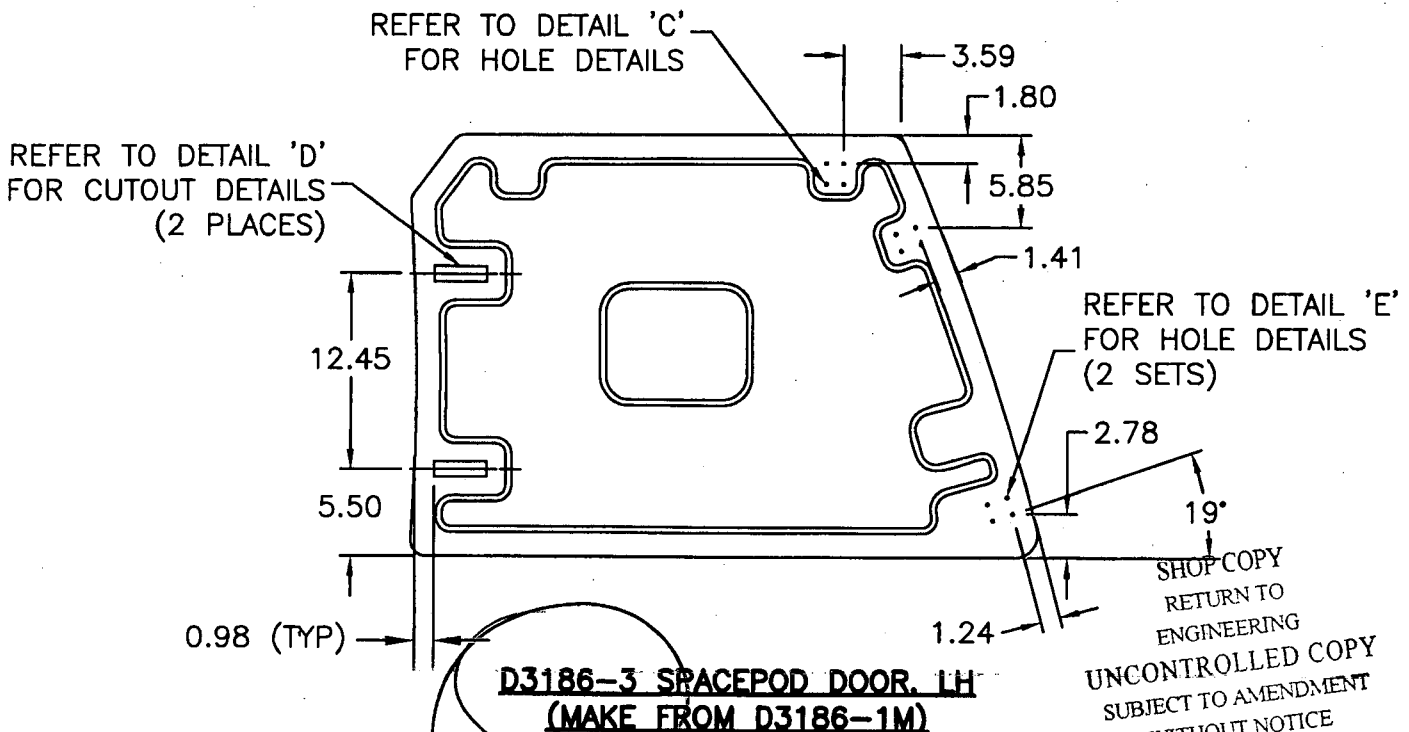
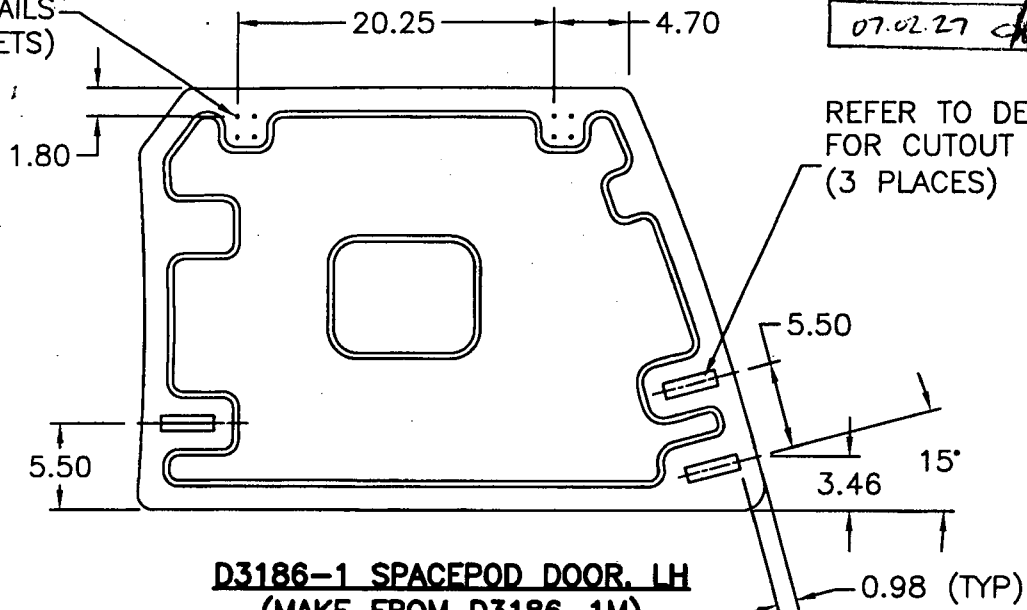
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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

REFER TO DETAIL 'C'
FOR HOLE DETAILS
(2 SETS)

**NOTES:**

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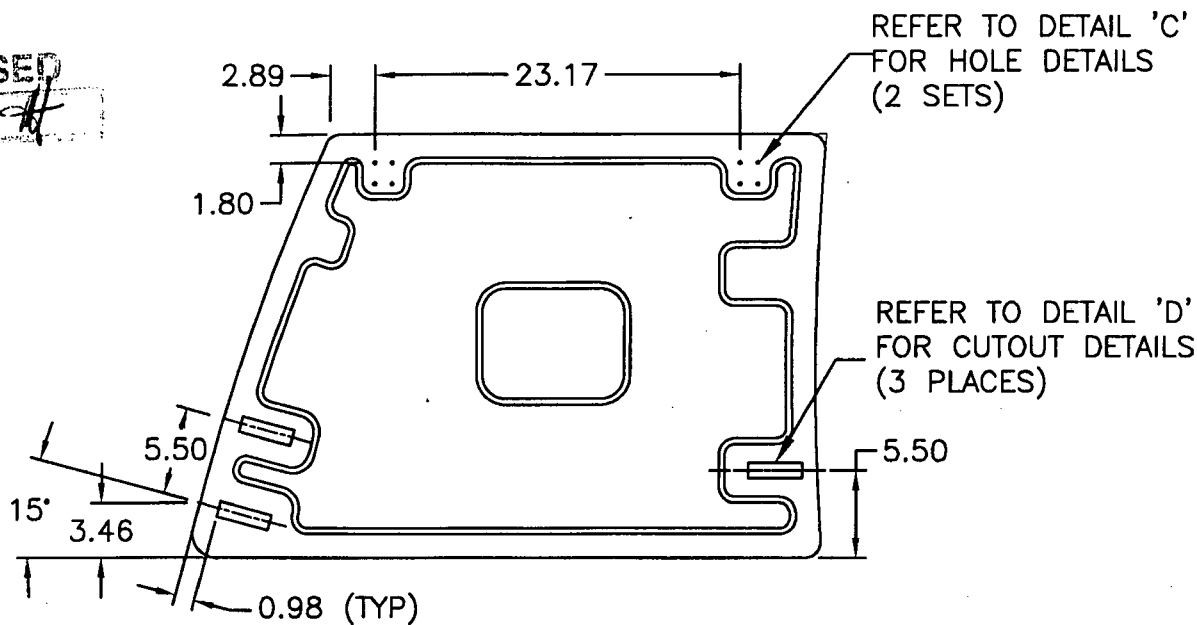
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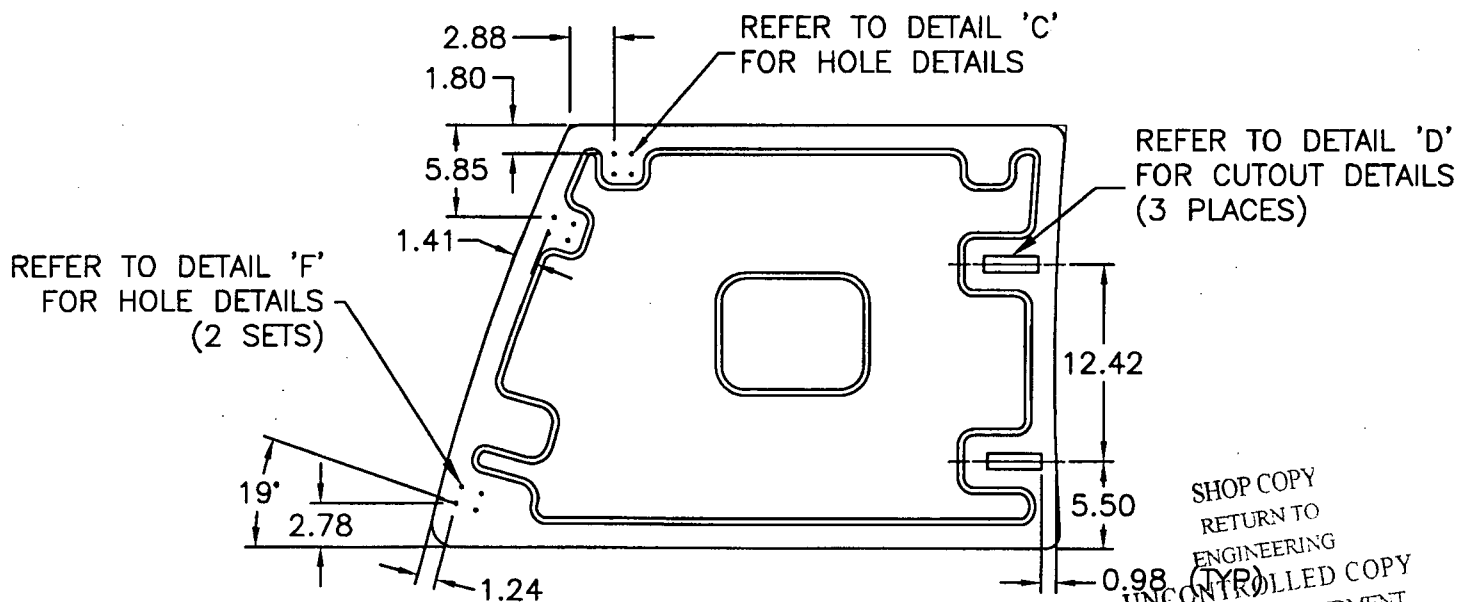


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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

RELEASED
07-02-27



D3186-2 SPACEPOD DOOR. RH
(MAKE FROM D3186-2M)



D3186-4 SPACEPOD DOOR. RH
(MAKE FROM D3186-2M)

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NO. 36014B

NOTES:

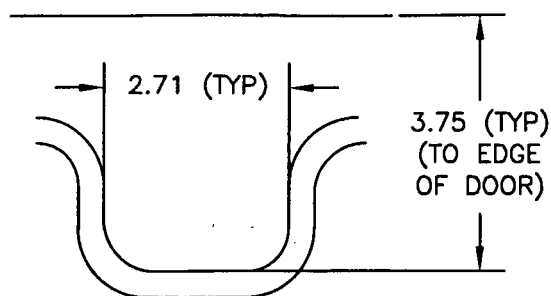
- 1) ALL DIMENSIONS ARE IN INCHES
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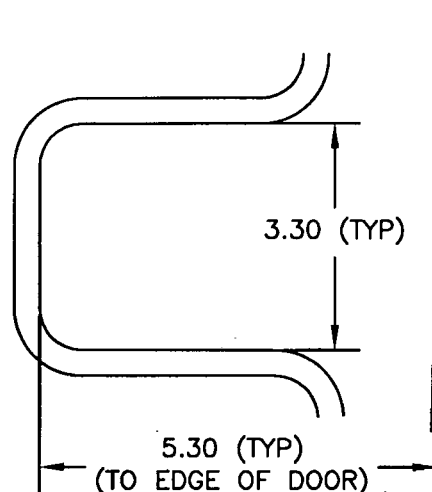
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DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS



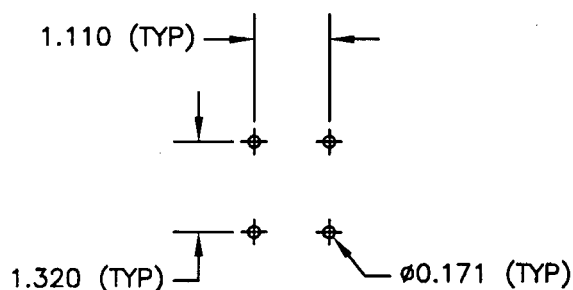
DETAIL A



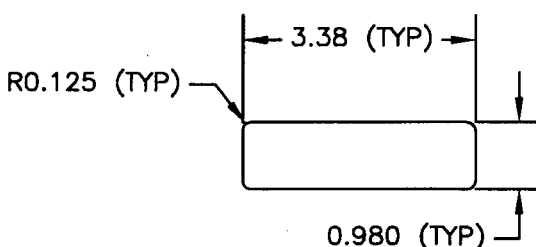
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RELEASED

07.02.27 [Signature]

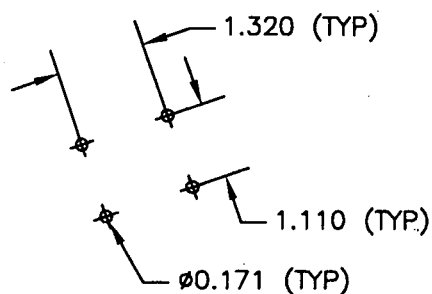


DETAIL C

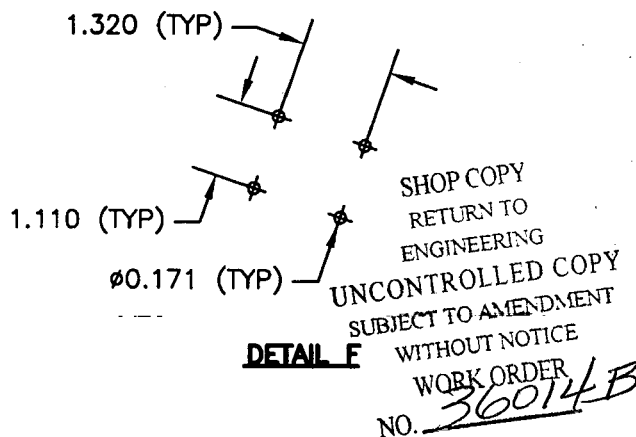


NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

DETAIL D



DETAIL E



NOTES:

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Date: Thursday, 11/29/2007 11:00:57 AM
 User: Kim Johnston

Process Sheet

50

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SPACEPOD BODY LH (355)
 Job Number : 36014A
 Estimate Number : 12637
 P.O. Number :
 This Issue : 11/29/2007 S.O. No. :
 Prsht Rev. : NC Part Number : D31883M
 First Issue : / / Type : SMALL /MED FAB Drawing Number : D3188 REV.E
 Previous Run : Project Number : N/A
 Material :
 Due Date : 12/12/2007 Qty: 1 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev: A New issue ech882 06-11-30 EC
 est rev B revD dwg 07.03.07 ec
 est rev C rev E dwg 07.04.16 EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2213 Aluminum Spacer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
 Ship To Delastek

8 D2213 Spacer Batch: 330107 C 207/11/30 (8)

2.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 5172
 Description: D3188-3M BODY
 SHIP: D2213 Spacers
 Supplier: Delastek
 Conformity Certificate and Process sheet required
 Ship 2 Items from Previous steps

C 207/11/30

(1)

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from Delastek is attached.

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3188 .Visual inspection. Check for void spot and pins.

C 207/12/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/29/2007 11:00:57 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD BODY LH (355)

Job Number: 36014A

Part Number: D31883M

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

mub 07/12/20

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 07/12/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

RELEASED

07.04.02

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
JB	CB	DRAWING NO.	REV. E	
CHECKED CE	APPROVED [Signature]	D3188	SHEET 1 OF 11	
DATE 07.04.02	TITLE SPACEPOD BODY	SCALE NTS		
A	03.04.03	NEW ISSUE		
B	06.10.06	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7		
C	06.12.13	REMOVED D0600-XXX LABELS		
D	07.02.22	UPDATE DIMENSIONS		
E	07.04.02	ADD HYSOL/FIBER OPTION ON SHEET 11		

GENERAL NOTES:

- 1) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
- 2) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
- 3) MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLESFOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

- 4) MOLD SCHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8500

- 5) APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
- 6) FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S
- 7) ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

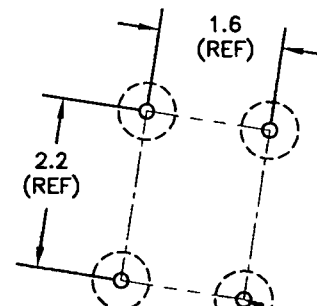
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WITHOUT NOTICE
WORK ORDER
NO. 360167A

DART

RELEASED

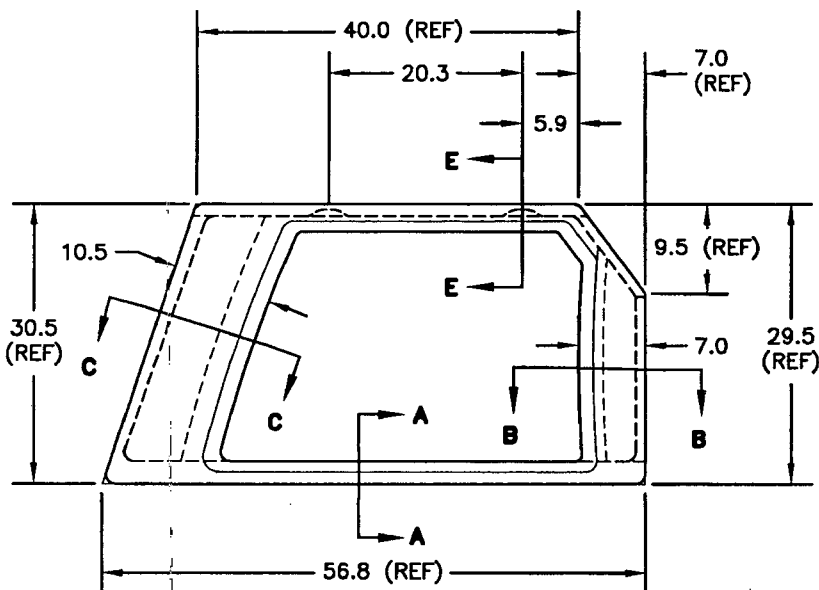
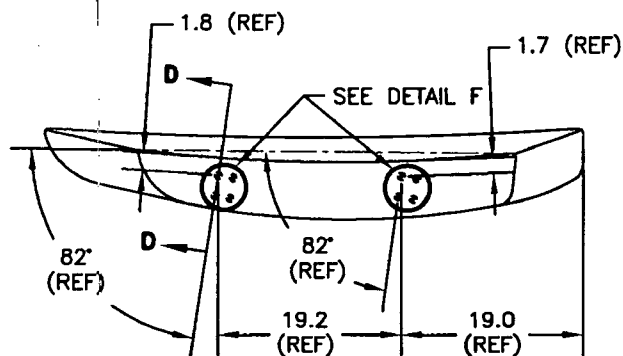
07-04-02

DESIGN	JB	DRAWN BY	CB	DART AEROSPACE LTD
CHECKED	CE	APPROVED	CB	HAMKESBURY, ONTARIO, CANADA
DATE	07.04.02	DRAWING NO.	D3188	REV. E
		TITLE	SPACEPOD BODY	SHEET 2 OF 11
		SCALE	NTS	

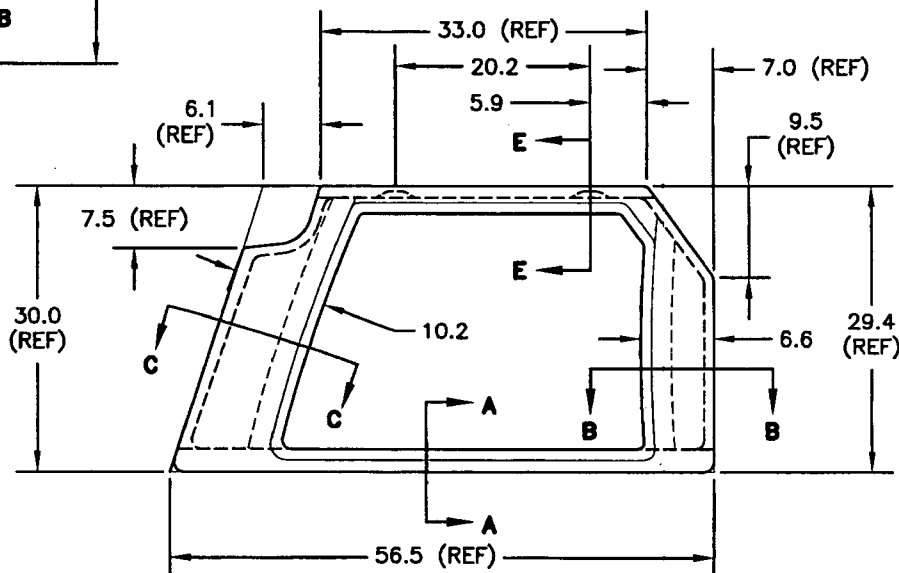
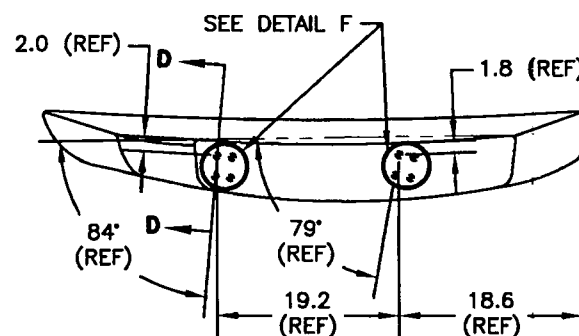


DETAIL F

INSTALL
D2213 SPACER
(8 PLACES)
(SEE SECTION D-D)



D3188-1M SPACEPOD BODY



D3188-3M SPACEPOD BODY

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WORK ORDER
NO. 360141

D3186-1M/-3M NOTES:

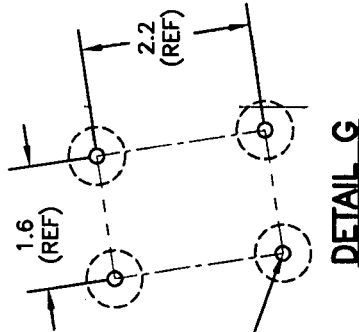
- 1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
- 2) SEE SHEET #4 FOR SECTION VIEWS.

DART

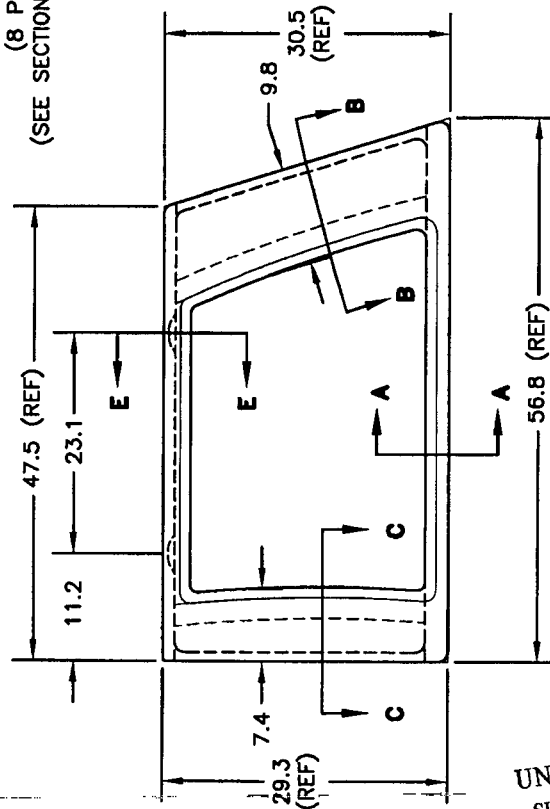
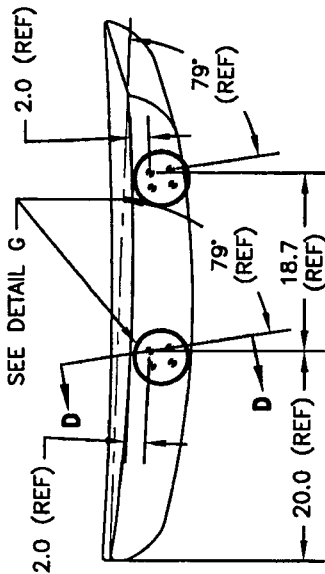
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CHECKED LE	APPROVED [Signature]	DRAWING NO. D3188	REV. E SHEET 3 OF 11
DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS

RELEASED

07.04.02 [Signature]



INSTALL
D2213 SPACER
(8 PLACES)
(SEE SECTION D-D)



D3188-2M SPACEPOD BODY

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NO. 3601 [Signature]

D3186-2M NOTES:
1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.
2) SEE SHEET #4 FOR SECTION VIEWS.

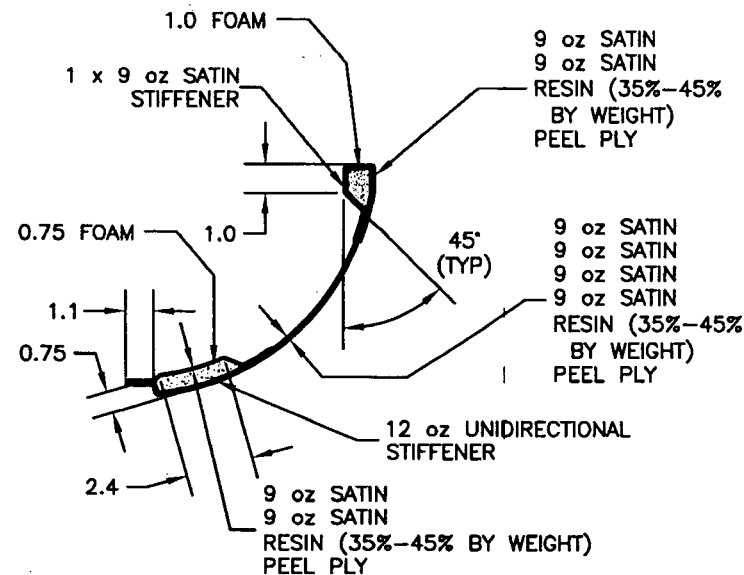
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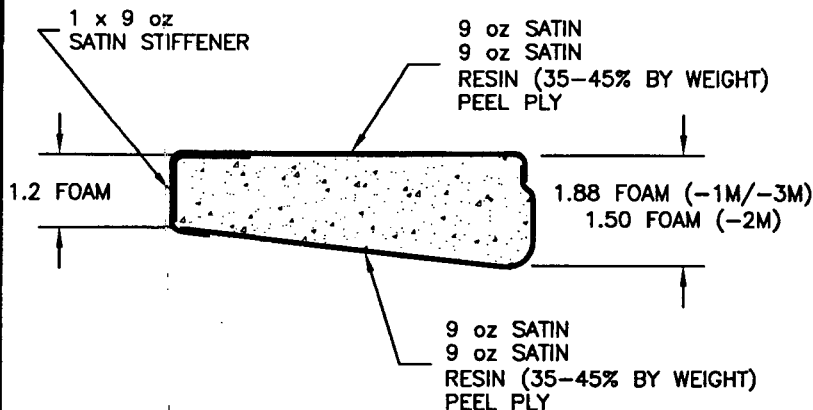
DART

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CHECKED	CE	APPROVED	[Signature]	DRAWING NO.	D3188
DATE	07.04.02	TITLE	SPACEPOD BODY	SHEET 4 OF 11	REV. E
		SCALE	NTS		

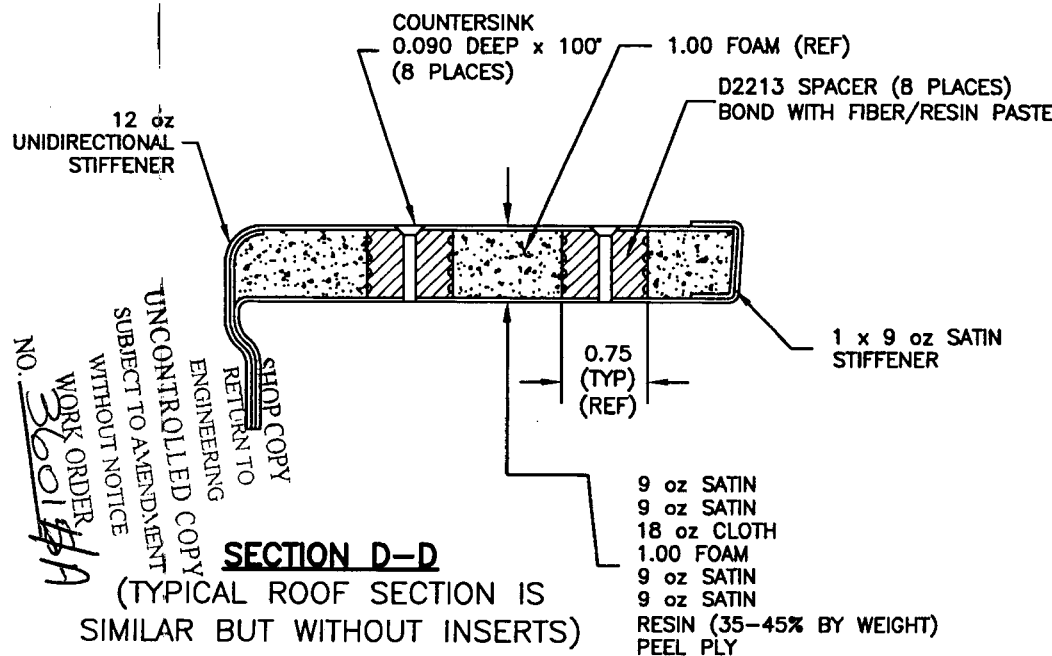
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07.04.02



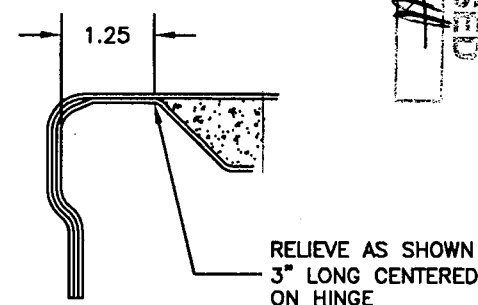
SECTION B-B
(SECTION C-C OPPOSITE)



SECTION A-A
(TYPICAL FLOOR SECTION)



SECTION D-D
(TYPICAL ROOF SECTION IS
SIMILAR BUT WITHOUT INSERTS)



SECTION E-E
(2 PLACES PER POD)

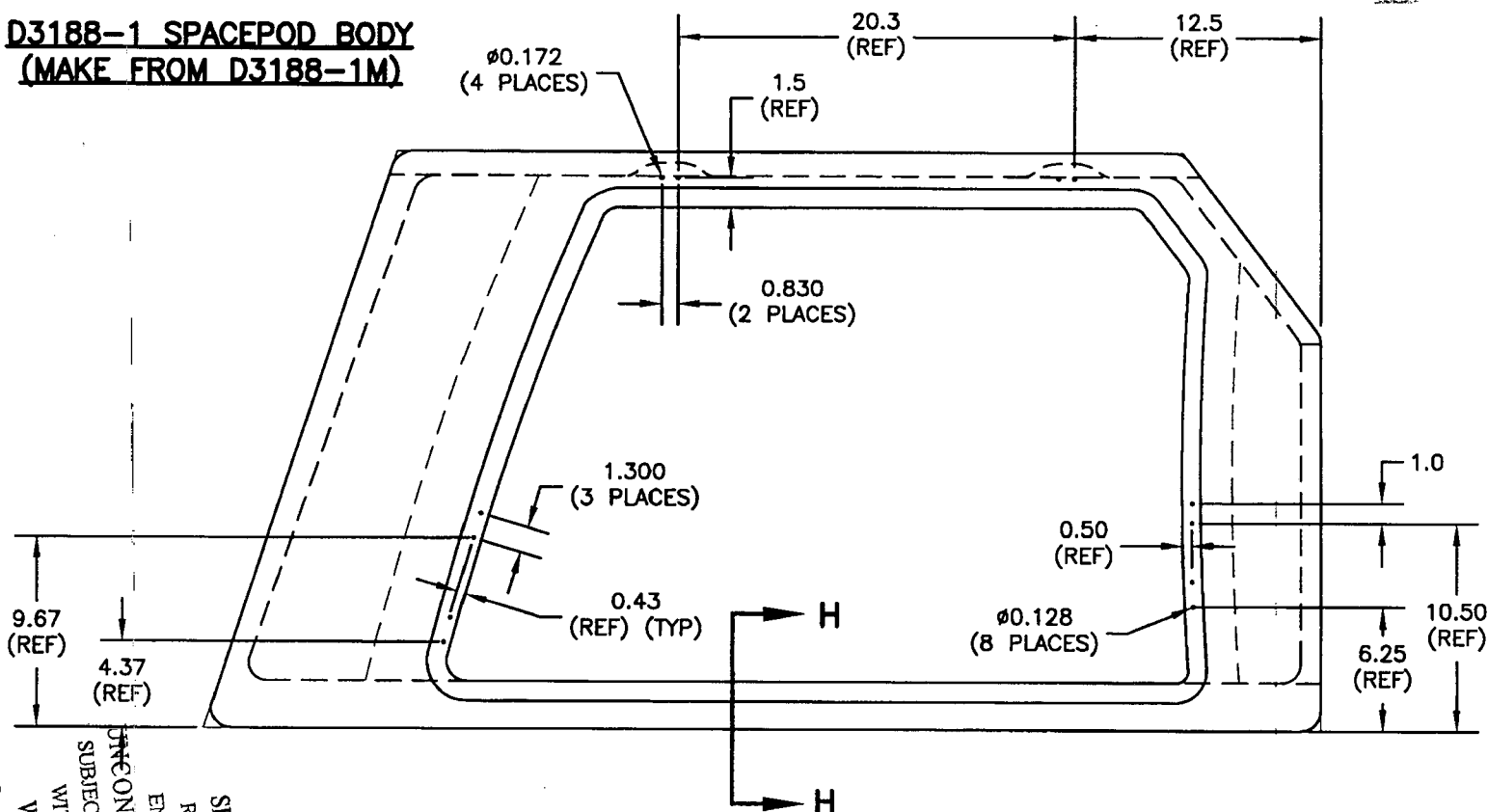
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DATE	07.04.02	DRAWING NO.	D3188	REV. E
TITLE	SPACEPOD BODY	SHEET	5 OF 11	SCALE
				NTS

RELEASED
07.04.02

D3188-1 SPACEPOD BODY
(MAKE FROM D3188-1M)



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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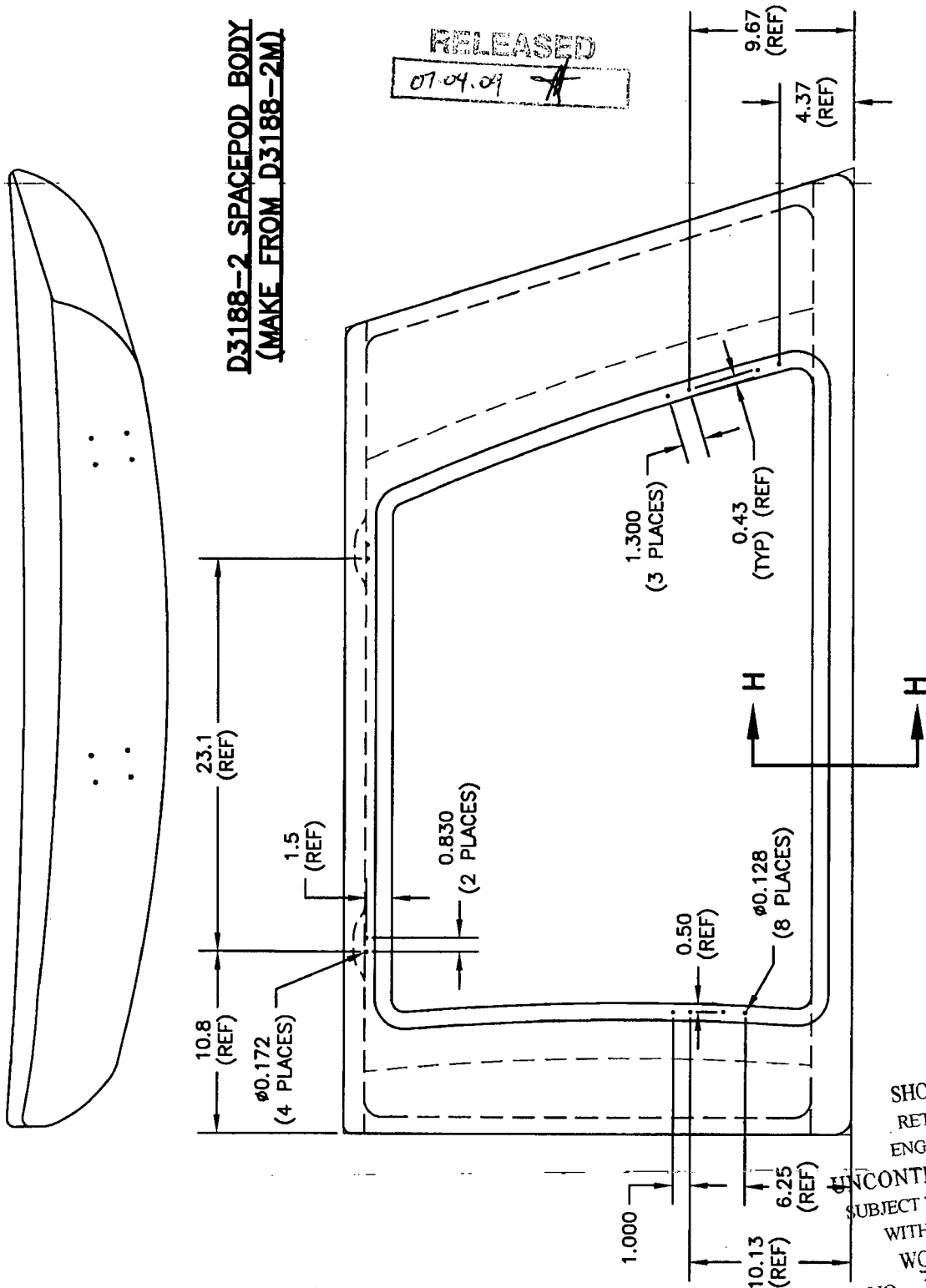
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DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS



NOTES:
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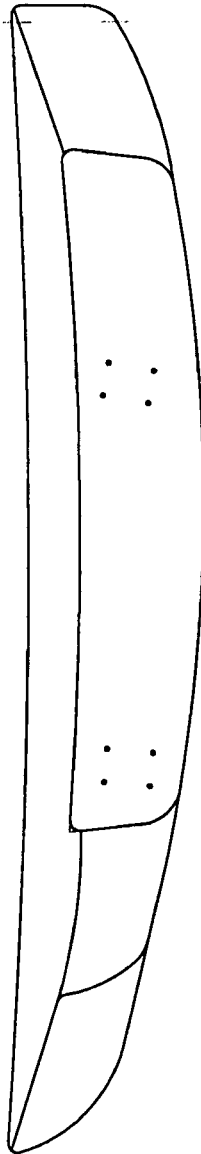
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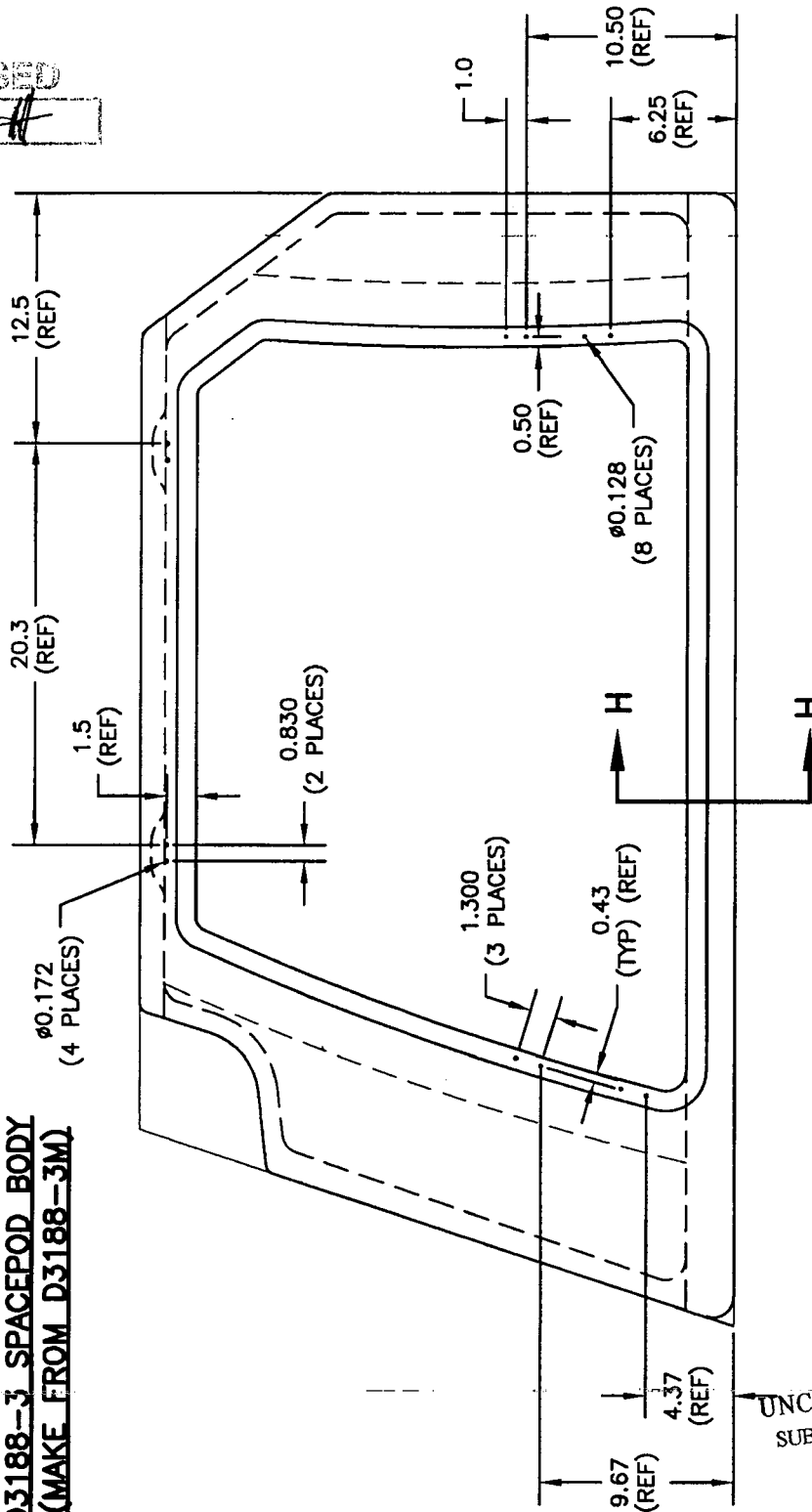
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DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS

RELEASED

07.04.09 H



**D3188-3 SPACEPOD BODY
(MAKE FROM D3188-3M)**



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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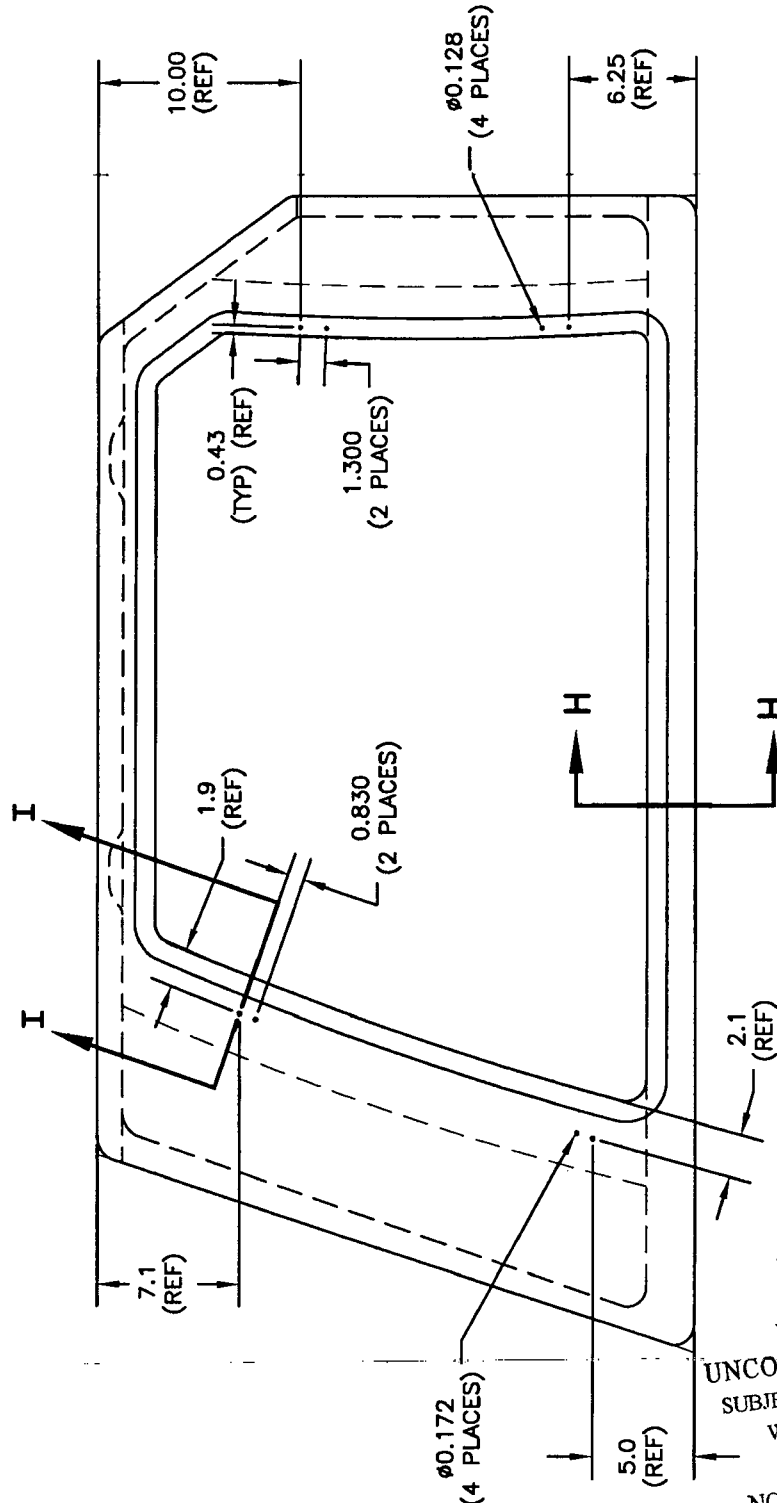
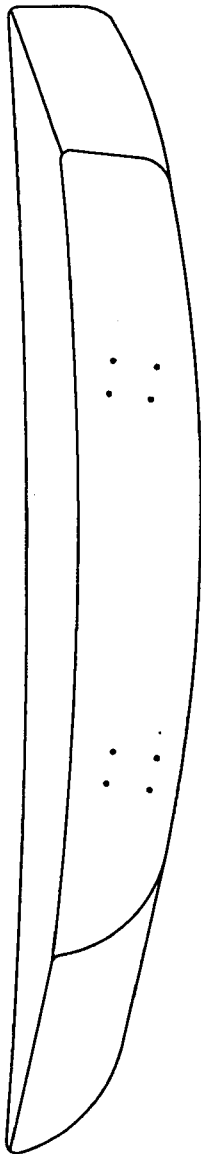
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CHECKED LE	APPROVED [Signature]	DRAWING NO. D3188	REV. E SHEET 8 OF 11
DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

RELEASED

07.04.02 [Signature]

D3188-5 SPACEPOD BODY
(MAKE FROM D3188-1M)



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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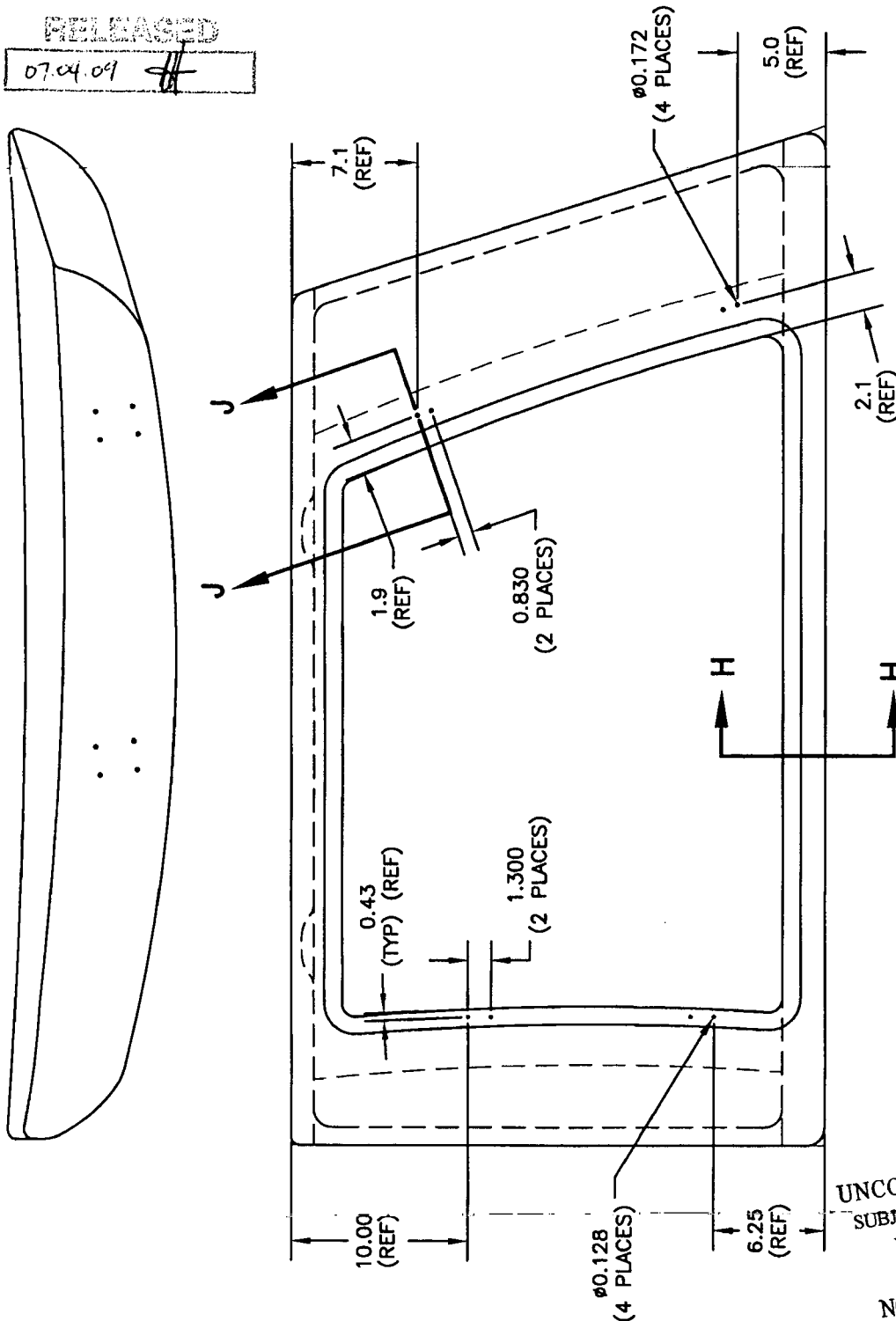
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CHECKED LE	APPROVED #	DRAWING NO. D3188	REV. E SHEET 9 OF 11
DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

RELEASED

07.04.09

D3188-6 SPACEPOD BODY
(MAKE FROM D3188-2M)



NOTES:
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEWS

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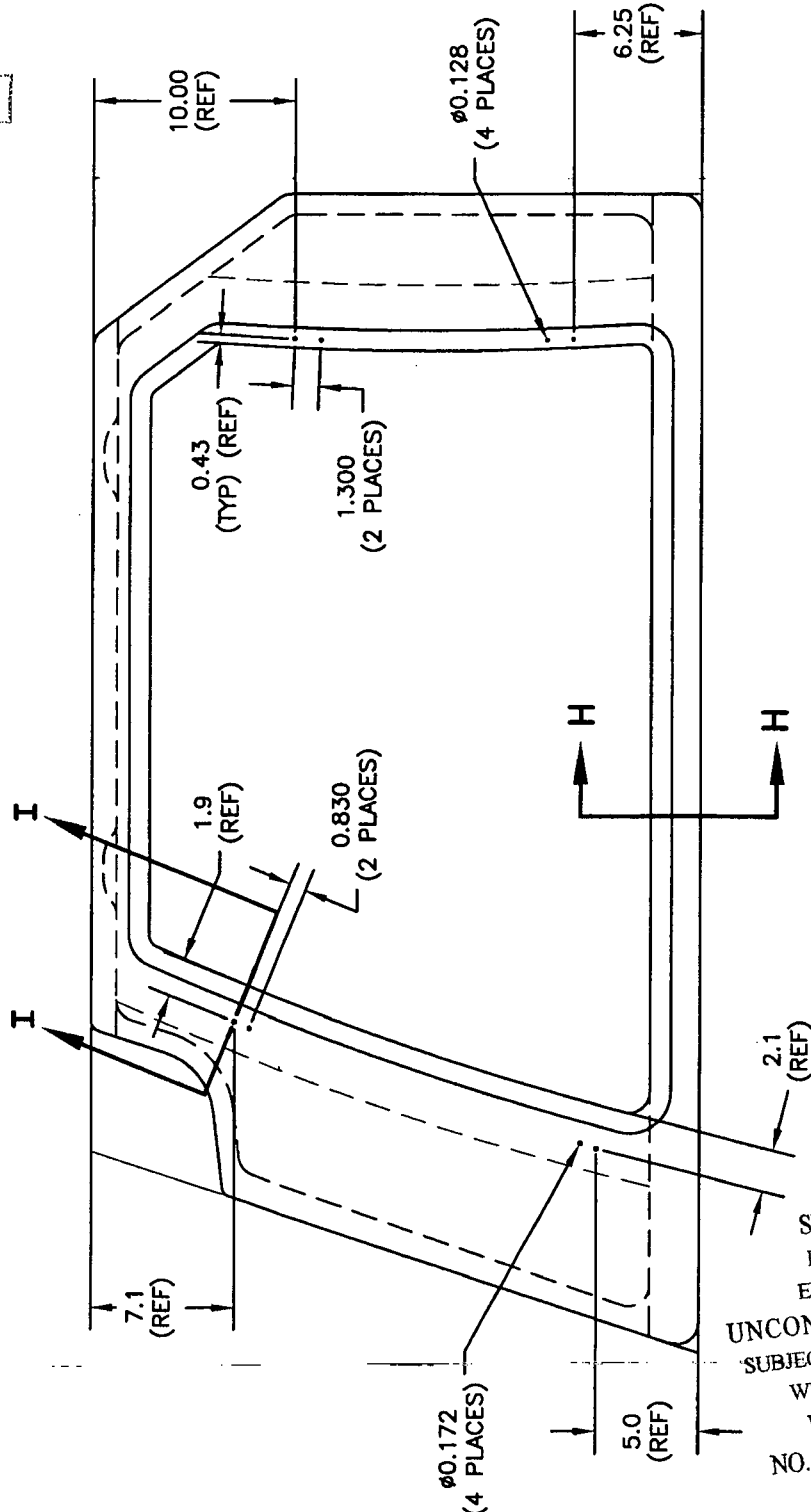
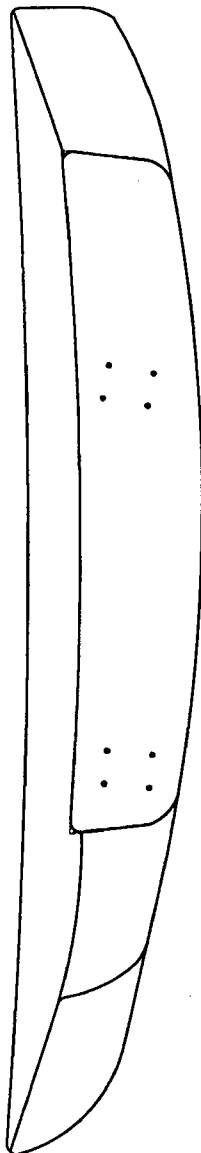
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CHECKED LE	APPROVED [Signature]	DRAWING NO. D3188	REV. E SHEET 10 OF 11
DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

RELEASED

07.04.02

D3188-7 SPACEPOD BODY
(MAKE FROM D3188-3M)



NOTE:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

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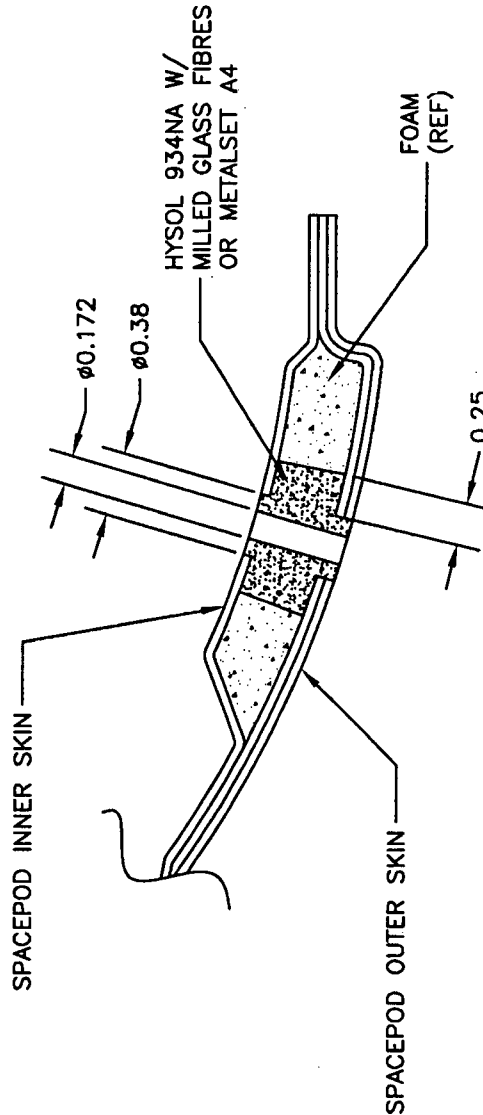
01.04.09 **[Signature]**

INSTALL AKS7-1032-130
INSERTS (29 PLACES)
PER D3188-1T1 (D3188-1/-3/-5/-7)
OR D3188-2T1 (D3188-2/-6)

FOAM
(REF)



SECTION H-H
(TYPICAL FLOOR SECTION)



SECTION I-I
(SECTION J-J OPPOSITE)
(4 PLACES PER POD)

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DELASTEK COMPOSITES INC.
2699, 5ième Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	12356
Customer #	DART

Telephone: (819) 533-5788
Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-5200
Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
Delastek Composites		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
19/12/2007	30/11/2007	5586	C. LAVOIE		PO00005172		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0058	D31861M Spacepod Door LH B36014B01 Dwg. Rév.: D <div>No. lot 42350</div> <div>Qté 1</div>			
1	0	1	DKC134-0061	D31883M Spacepod Body LH B36014A Dwg. Rév.: E Job: 42354			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by: _____
Quality department AQ-357

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Date: Thursday, 11/29/2007 11:01:00 AM
 User: Kim Johnston

Process Sheet

50

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SPACEPOD DOOR LH
 Job Number : 36014B01
 Estimate Number : 12598
 P.O. Number :
 This Issue : 11/29/2007 S.O. No. :
 Prsht Rev. : NC
 First Issue : 11 Type : SMALL /MED FAB
 Previous Run : 35395B01
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A New Issue 06-12-04 ec
 est rev D rv D dwg 07.03.07 ec

Part Number : D31861M
 Drawing Number : D3186 REV.D
 Project Number : N/A
 Drawing Revision : D
 Material :
 Due Date : 12/12/2007 Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 5172

C 20711/30

Description: D3186-1M Door

Supplier: Delastek

①

Conformity Certificate and Process sheet required

2.0 D31861P Spacepod Door



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Spacepod Door

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from
 Delastek is attached.

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3186 .Visual inspection. Check for void spot and pins. Ensure surface of
 doo is smooth, no dimples for drilling.

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

mlo 7/12/20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/29/2007 11:01:00 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD DOOR LH

Job Number: 36014B01

Part Number: D31861M

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 8/12/24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

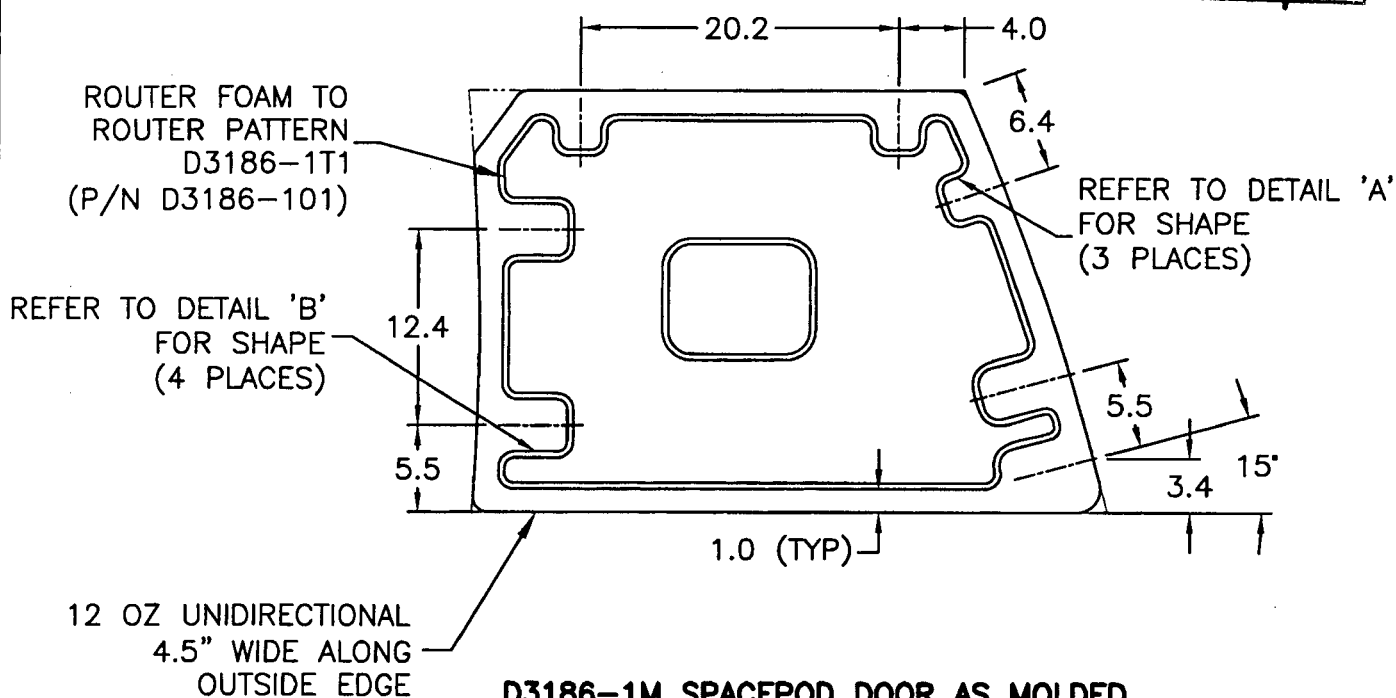
DESIGN DS	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3186	REV. D SHEET 1 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS
A	03.03.27	NEW ISSUE	
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED

07.02.27

**D3186-1M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYLCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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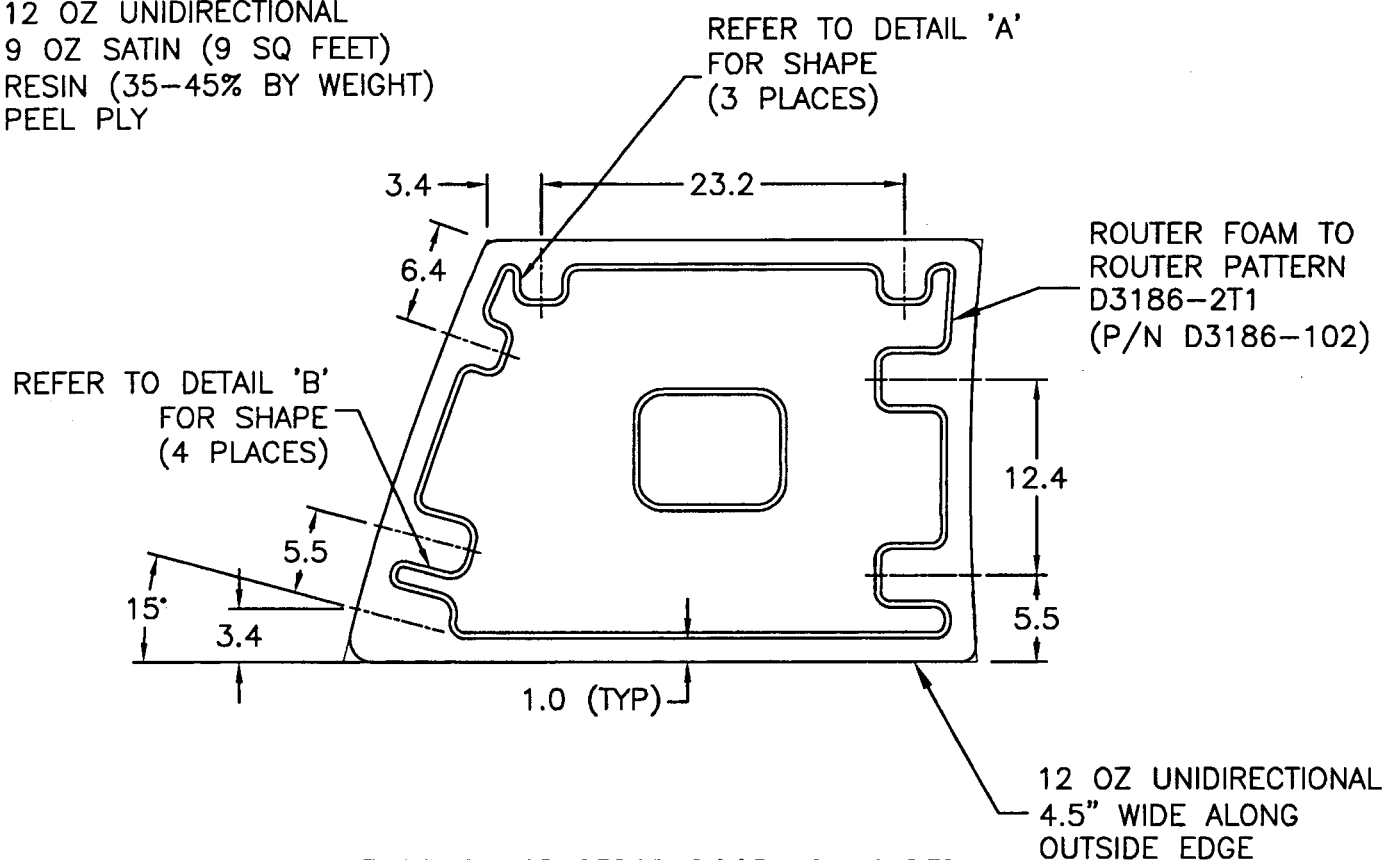
DESIGN DS—	DRAWN BY LE—	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3186	REV. D SHEET 2 OF 5
DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35–45% BY WEIGHT)
PEEL PLY

RELEASED

07.02.27 H

**D3186-2M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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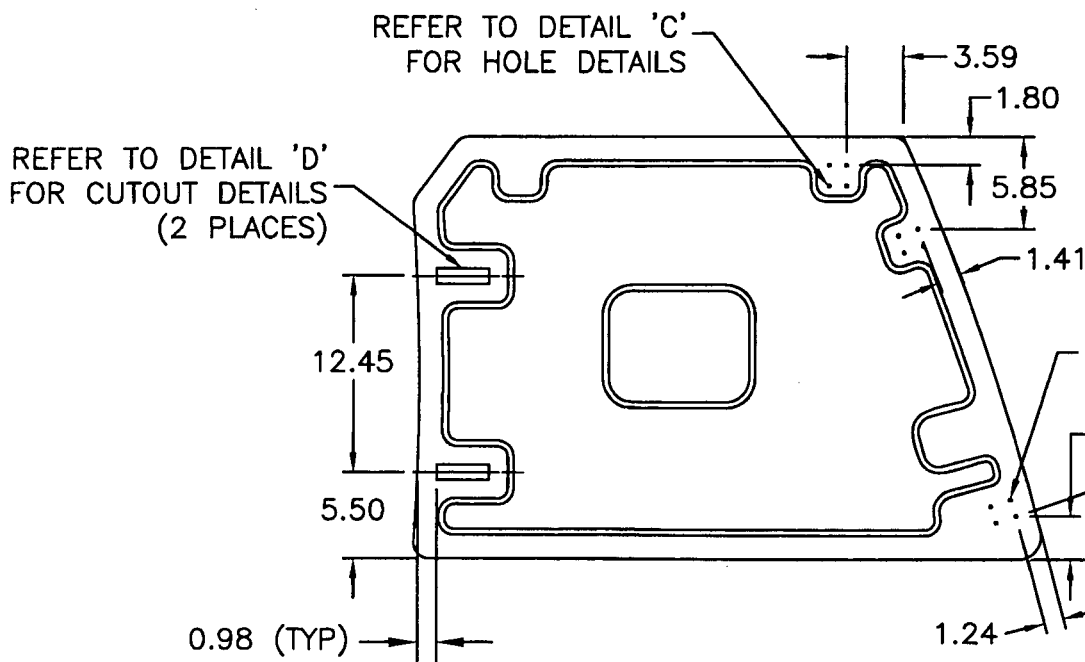
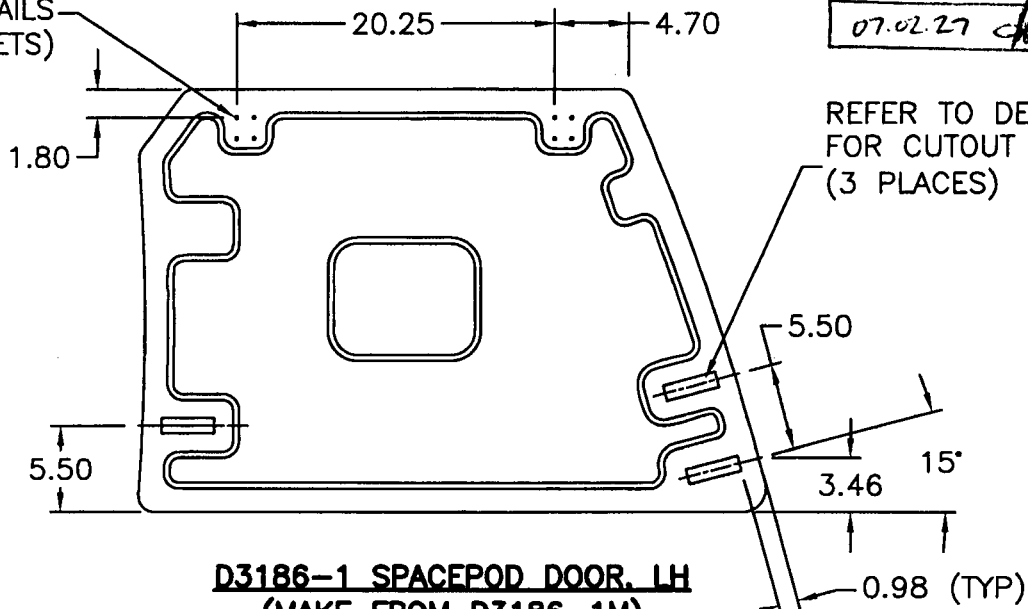
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DESIGN DS	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3186	REV. D SHEET 3 OF 5
DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS

REFER TO DETAIL 'C'
FOR HOLE DETAILS
(2 SETS)



NOTES:

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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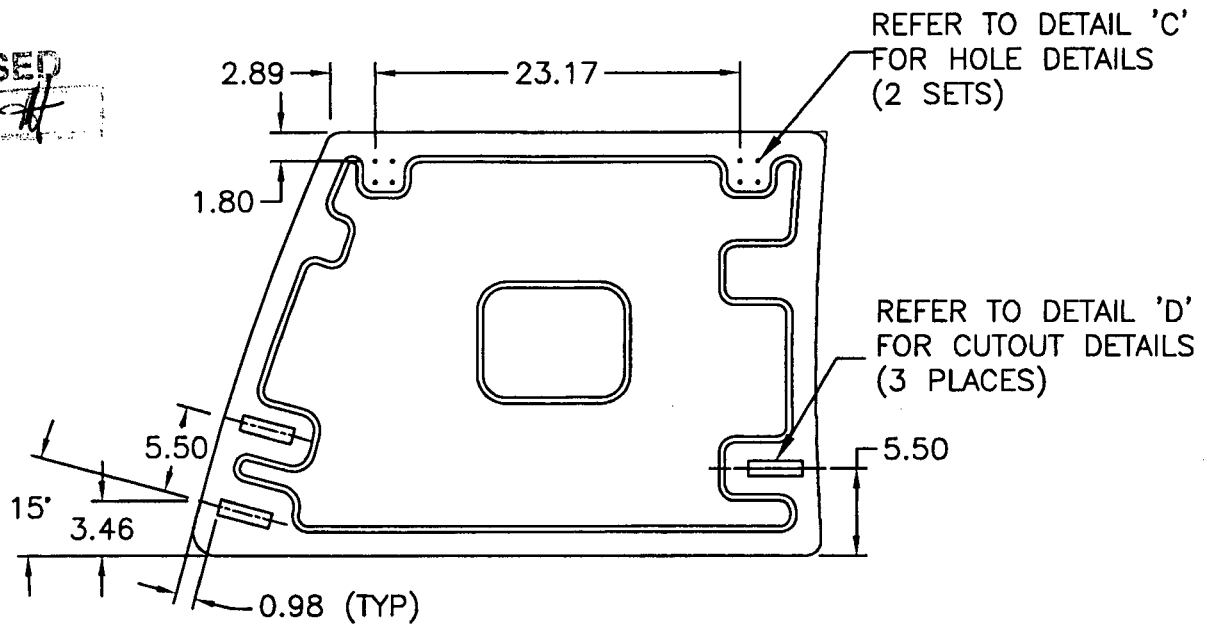
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NO. 36014 B01

DART

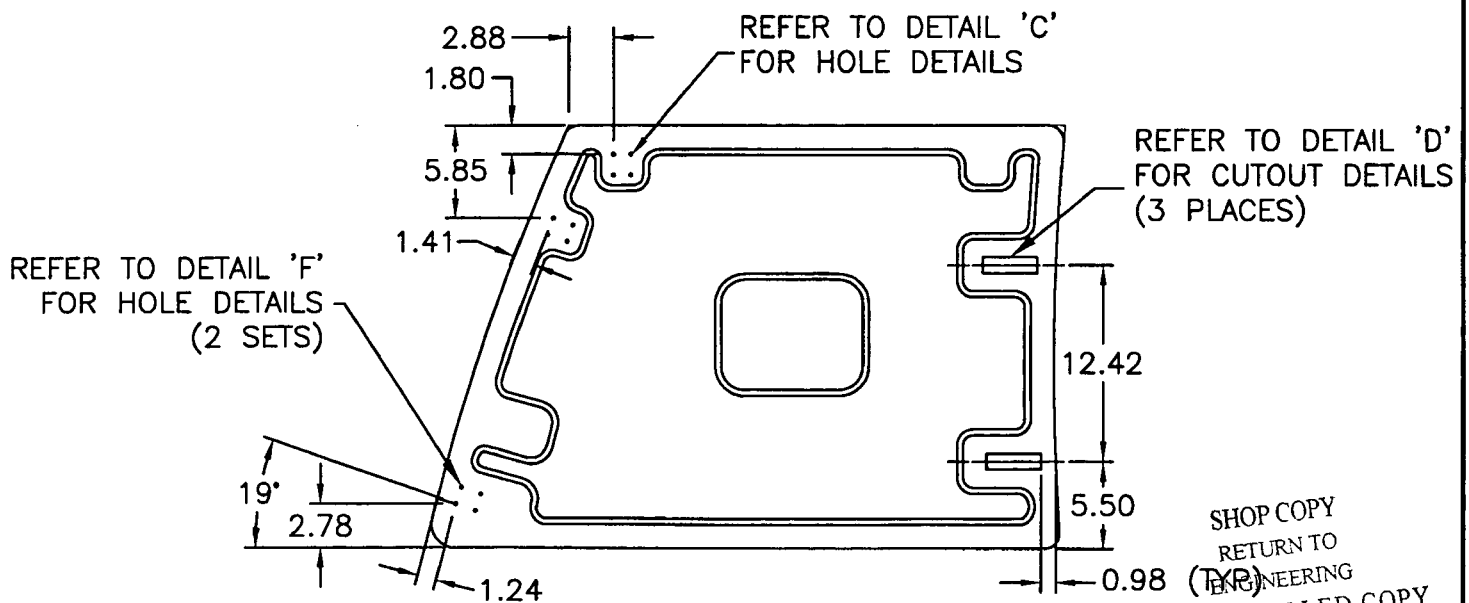
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3186	REV. D SHEET 4 OF 5
DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS

RELEASED

07-02-27



D3186-2 SPACEPOD DOOR. RH
(MAKE FROM D3186-2M)



D3186-4 SPACEPOD DOOR. RH
(MAKE FROM D3186-2M)

NOTES:

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

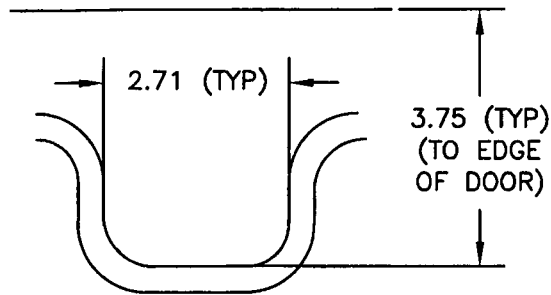
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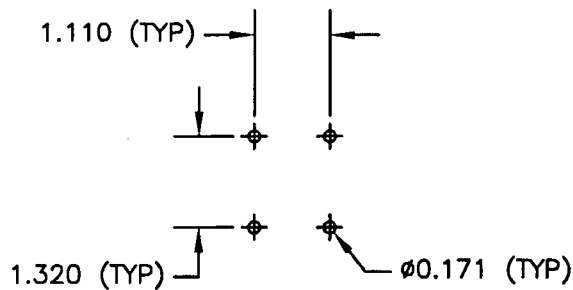
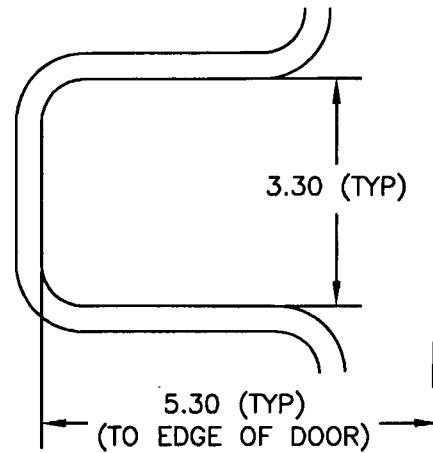
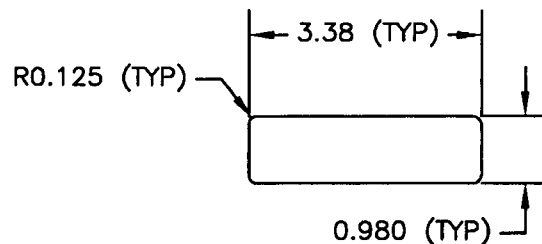
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DART

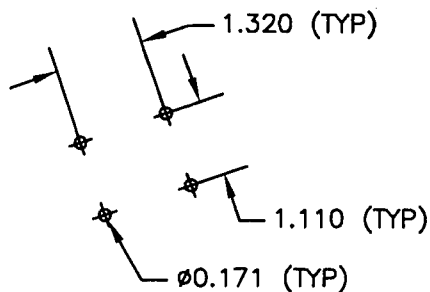
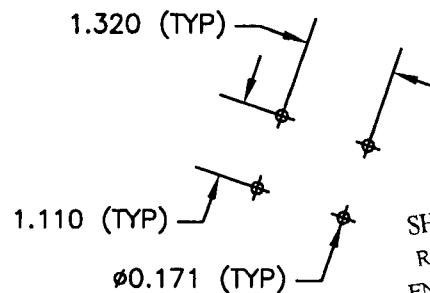
DESIGN DS	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3186	REV. D SHEET 5 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

**DETAIL A****RELEASED**

07.02.27

**DETAIL C****DETAIL B**

NOTE: ENSURE THAT CUTOUT IS
PERPENDICULAR TO EDGE OF DOOR

DETAIL D**DETAIL E****DETAIL F****NOTES:**

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DELASTEK COMPOSITES INC.
2699, 5ième Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	12356
Customer #	DART

Telephone: (819) 533-5788
Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-5200
Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
Delastek Composites		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
19/12/2007	30/11/2007	5586	C. LAVOIE		PO00005172		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0058	D31861M Spacepod Door LH B36014B01 U de M : Ea Dwg. Rév.: D			
				No. lot		Qté	
				42350		1	
1	0	1	DKC134-0061	D31883M Spacepod Body LH B36014A U de M : Ea Dwg. Rév.: E Job: 42354			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by: _____
Quality department AQ-357

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Date: Lundi, 2007-12-03 11:43:11
 Utilisateur: Marc Dubé

Feuille de Procédé

Client : DART Dart Aerospace Ltd.	Nom Dessin : SP/ EPOD DOOR
Numéro Job : 42350	Numéro Article : DKC 34-0058
Numéro Soumission : 2608	Numéro Dessin : D31 3
Numéro B.A. :	Projet Numéro : DKC 34
Cette fois : 2007-12-03 No. B.V. :	Révision dessin : D
Prsht Rev. : NC	Matériel : Fibr 7781 et Résine 411-350
Prem. fois : - - Type :	Date Dûe : 2007-12-10 Qté: 1 Udm: UNITE
Job précédente :	

 Écrit par : _____
 Vérifié & Approuvé par : _____
 Commentaires : N° de pièce Dart Aerospace : D31861M

Process Sheet Rév.: 00 Création du premier.

Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

1.0	AC0303	Frekote 44NC
-----	--------	--------------

Commentair Qty.:	0.020 GALLON(s)/Unit	Total :	0.020 GALLON(s)
Frekote 44NC			

2.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
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Commentair Setup:	0.00Hrs/ Run: 5.0000Min	Total Run : 0.0833Hrs
PRÉPARATION DU MOULE		

Faire la préparation du moule N° DT 8005 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon le QSI-006.

Date: 11/10/07 Heure Début: 12:40 Heure Fin: 11:00 Sceau:



3.0	AC0409	Tissu à délaminer Release ply B
-----	--------	---------------------------------

Commentair Qty.:	3.28 VERGE(s)/Unit	Total :	3.28 VERGE(s)
Tissu à délaminer Release ply B			

4.0	AC0407	Wrightlon 5200 Bleu P3
-----	--------	------------------------

Commentair Qty.:	3.59 VERGE(s)/Unit	Total :	3.59 VERGE(s)
Wrightlon 5200 Bleu P3			

5.0	AC0408	Feutre de drainage N° Airweave N 10
-----	--------	-------------------------------------

Commentair Qty.:	3.00 VERGE(s)/Unit	Total :	3.00 VERGE(s)
Feutre de drainage N° Airweave N 10			

6.0	AC0752	Stretchlon 200 poche à vide Vert
-----	--------	----------------------------------

Commentair Qty.:	3.00 VERGE(s)/Unit	Total :	3.00 VERGE(s)
Stretchlon 200 poche à vide Vert			

Date: Lundi, 2007-12-03 11:43:11

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd. ---

Nom Dessin: SPACEPOOR

Numéro Job: 42350

Numéro Article: DKC134-00

Numéro Job:



Séq.: Machine ou Opération: Description :

7.0 AAC0681 9.7 oz Weave #FG-778150-125Y Volan Fini

Commentaire Qty.: 4.500 VERGE(s)/Unit Total: 4.500 VERGE(s)

9.7 oz Weave #FG-778150-125Y Volan Finish # LOT: 1-6170-1

8.0 AC0098 Ruban à gommer jaune #: T/AT-200Y

Commentaire Qty.: 2.2500 RL(s)/Unit Total: 2.2500 RL(s)

Ruban à gommer jaune #: T/AT-200Y

9.0 AAC0443 Fiberglass 12 oz Unidirectional

Commentaire Qty.: 1.00 VERGE CAR(s)/Unit Total: 1.00 VERGE CAR(s)

Fiberglass 12 oz Unidirectional N° de Lot: 1-6170-3

10.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run: 0.5000Hrs
TAILLAGE DU MATÉRIEL

Tailler le matériel, selon les différents patrons de découpe :

Appliquer le Ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le côté non en contact avec le sac à vide.

À fin d'accélérer le processus de taillage, tailler les plis de 9.7 oz tous en même temps en les superposants les uns sur les autres.

Date: 3/10/07 Heure Début: 9:15 Heure Fin: 11:00 Sceau: N.T

11.0 AAC0275 Catalyst N° DDM-9

Commentaire Qty.: 0.0080 PINTE(s)/Unit Total: 0.0080 PINTE(s)

Catalyst N° DDM-9 N° de Lot: 1-6118-3

12.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentaire Qty.: 0.500 KILOGRAMME(s)/Unit Total: 0.500 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-6330

13.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 03/10/07 Heure Début: 1:50 Heure Fin: 2:00 Sceau:



Date: Lundi, 2007-12-03 11:43:11

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.—

Nom Dessin: SPACEPOOL DOOR

Numéro Job: 42350

Numéro Article: DKC134-00

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

14.0	LAMINAGE.	LAMINAGE PIÈCE DART
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Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
FAIRE LE LAMINAGE DES TISSUS

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8305 et ensuite imbiber un pli de tissu 9.7oz.

Recommencer l'opération pour le deuxième pli.

Date: 3/10/07 Heure Début: 2:00 Heure Fin: 2:30 Sceau:

15.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE
------	----------------	-----------------------



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: 3/10/07 Heure Début: 2:30 Heure Fin: 2:40 Sceau:

Curing Début: 2:00 Curing Fin: 9:05

16.0	AAC0275	Catalyst N° DDM-9
------	---------	-------------------

Commentaire Qty.: 0.0120 PINTE(s)/Unit Total : 0.0120 PINTE(s)
Catalyst N° DDM-9.

N° de Lot: 1-6118-1

17.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.
------	---------	---

Commentaire Qty.: 0.300 KILOGRAMME(s)/Unit Total : 0.300 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6330-1

Date: Lundi, 2007-12-03 11:42:31

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOOR

Numéro Job: 42350

Numéro Article: DKC134-00

Numéro Job:



Séq.:

Machine ou Opération:

Description :

18.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350 Imbiber toutes les surfaces du foam core.

Laisse sécher pendant 2 heures.

Date: 3/10/07 Heure Début: 8:00 Heure Fin: 8:30 Sceau: C.G.



19.0

DKC134-0056

Foam Core N° D3186-101 (Porte D3186-1)

Commentaire Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)
Foam Core N° D3186-101 (Porte D3186-1)

N° de Job: 42016

20.0

AAC0452

Polybond B46F

Commentaire Qty.: 0.082 KIT(s)/Unit Total : 0.082 KIT(s)
Polybond B46F N° de Lot: 1-6253-1

21.0

ASSEMBLAGE 3

ASSEMBLAGE GÉNÉRALE DART



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
ASSEMBLAGE GÉNÉRALE DES PIÈCES

Retirez le bagging.

Pour aider au positionnement de 12 oz., positionner le gabarit de trimage dans le moule et tracer son contour sur le 9 oz. Retirez le gabarit de trimage.

Positionner le foam core à l'aide du gabarit prévu à cet effet et tracer le contour sur le 9 oz. (Vous devriez maintenant avoir 2 contours de tracé sur le 9 oz.)

L'inspection du positionnement doit être fait par le département de la qualité.

Date: 4/10/07 Sceau: Initiales: G.G.

Appliquer une couche de Polybond B64F à l'endos du Foam Core N° DKC134-0056 et positionner le foam Core sur le moule selon le dessin, et selon les lignes de positionnement prévues à cet effet.

Date: 23/10/07 Heure Début: 12:50 Heure Fin: 1:00 Sceau:



Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOOR DOOR

Numéro Job: 42350

Numéro Article: DKC134-003

Numéro Job:



Séq.:

Machine ou Opération:

Description :

22.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE




Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer
- 2- Feutre de drainage
- 3- Sac à vide Stretchlon 200

Laisser sécher pendant 2 heures minimum.

Retirez le bagging avant la fin de la polymérisation (entre 1 heure et 1heure 1/2) et d'enlever le surplus de polybond.

Date: 23/10/07 Heure Début: 1:00 Heure Fin: 1:05 Sceau: 

Curing Début: 12:50 Curing Fin: 2:50

23.0

AAC0275

Catalyst N° DDM-9

Commentaire Qty.: 0.0400 PINTE(s)/Unit Total : 0.0400 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 1-6330-1 1-6118-1



24.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentaire Qty.: 1.000 KILOGRAMME(s)/Unit Total : 1.000 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6330-1

25.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantités requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 24/10/07 Heure Début: 8:00 Heure Fin: 8:05 Sceau: 

Date: Lundi, 2007-12-03 11:42:31

Utilisateur: Marc Dubé

Feuille de Procédé

Cliant: DART Dart Aerospace Ltd.---

Nom Dessin: SPACEPOI DOOR

Numéro Job: 42350

Numéro Article: DKC134-00 3

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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26.0	LAMINAGE.	LAMINAGE PIÈCE DART
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Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

FAIRE LE LAMINAGE DES TISSUS

Faire le laminage d'un pli de 9.7 oz.

Faire le laminage du pli de tissu de 12 oz tout le tour de la porte .

Faire le laminage du dernier pli de 9.7 oz.

Date: 24/10/07 Heure Début: 8:05 Heure Fin: 8:35 Sceau:



27.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE
------	----------------	-----------------------



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: 24/10/07 Heure Début: 8:35 Heure Fin: 8:45 Sceau:



Curing Début: 8:05 Curing Fin: 12:30

28.0	DÉMOULAGE 1	DÉMOULAGE PIÈCE DART
------	-------------	----------------------



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

DÉMOULAGE DES PIÈCES

- ① Démouler la pièce en faisant bien attention de ne pas abimer les coins et le " edge: '.
- ② Sabler la surface de la pièce qui était en contact avec le moule pour éliminer le fini :se de cel ii-ci

Date: 11/12/07 Heure Début: 10:55 Heure Fin: 11:00 Sceau:



② 11:12:07 11:30 11:55



Date: Lundi, 2007-12-03 11:42:31
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd. Nom Dessin: SPACEPO DOOR
Numéro Job: 42350 Numéro Article: DKC134-008

Numéro Job:



Séq.: Machine ou Opération: Description :

29.0 TRIMAGE 3 TRIMAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
TRIMAGE DE FINITION

Trimer le contour de la pièce à l'aide du gabarit de trimage prévu à cet effet.

Date: 11/12/07 Heure Début: 11:00 Heure Fin: 11:25 Sceau:



30.0 AAC0683 Dupont Primer N° 7704S

Commentair Qty.: 0.1390 UNITE(s)/Unit Total : 0.1390 UNITE(s)
Dupont Primer N° 7704S N° de Lot: 1-6440-1

31.0 AAC0670 Dupont Activator N° 7975S

Commentair Qty.: 0.2800 PINTE(s)/Unit Total : 0.2800 PINTE(s)
Dupont Activator N° 7975S 1-6440-1

32.0 AAC0672 Dupont Reducer N° 12375S

Commentair Qty.: 0.0350 GALLON(s)/Unit Total : 0.0350 GALLON(s)
Dupont Reducer N° 12375S N/A

33.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
PRÉPARATION DU MATÉRIEL DART

Bien brasser les trois contenants servant à faire le mélange du primer gris N° 110. et ensuite faire le mélange selon les instruction du fabriquant.

Date: 11/12/07 Sceau:



Date: Sceau:

34.0 PEINT/ PRIMER2 PEINTURE / PRIMER DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
PEINTURE / PRIMER DART

Appliquer la première couche de primer Dupont N° 7704S (7975S Activator, 12375S Reducer) selon I.G. #
Application du primer.

Laisser sécher pendant 3 heures.

Date: 11/12/07 Heure Début: 1:05 Heure Fin: 1:45 Sceau:



Date: Lundi, 2007-12-03 11:42:31

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOOL

Numéro Job: 42350

Numéro Article: DKC134-00

Numéro Job:



Séq.: Machine ou Opération: Description :

35.0 FINITION 3 FINITION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
FINITION PIÈCE DART

Sabler la pièce à l'aide de papier sablé grit 220 afin de corriger les imperfections et niveler le lustre du
primer.

36.0 AC0058 Polysoft 1.3 kg # 003012 Sikkens

Commentaire Qty.: 0.050 UNITE(s)/Unit Total : 0.050 UNITE(s)
Polysoft 1.3 kg # 003012 Sikkens

37.0 AAC0646 MASTIC POLYSOFT SIKKENS 3AR591

Commentaire Qty.: 0.050 KIT(s)/Unit Total : 0.050 KIT(s)
MASTIC POLYSTOP SIKKENS 3AR591

7-6284-1

38.0 AC0059 Durcisseur Polysoft #004009 Sikkens

Commentaire Qty.: 0.039 UNITE(s)/Unit Total : 0.039 UNITE(s)
Durcisseur Polysoft #004009 Sikkens

N° de Lot: 1-6284-1

39.0 FINITION 3 FINITION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
FINITION GÉNÉRALE

Faire les réparations de finition s'il y a lieu, à l'aide de sikkens.

Date: 17.12.07 Heure Début: 11:30 Heure Fin: 1:30 Sceau:



40.0 AAC0683 Dupont Primer N° 7704S

Commentaire Qty.: 0.1390 UNITE(s)/Unit Total : 0.1390 UNITE(s)
Dupont Primer N° 7704S

N° de Lot: 1-6440-1

41.0 AAC0670 Dupont Activator N° 7975S

Commentaire Qty.: 0.2800 PINTE(s)/Unit Total : 0.2800 PINTE(s)
Dupont Activator N° 7975S

N° de Lot: 2-6440-2

42.0 AAC0672 Dupont Reducer N° 12375S

Commentaire Qty.: 0.0350 GALLON(s)/Unit Total : 0.0350 GALLON(s)
Dupont Reducer N° 12375S

N° de Lot: N/A

43.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
PRÉPARATION DU MATÉRIEL

Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104 et ensuite faire le
mélange selon les instruction du fabriquant.

Date: Lundi, 2007-12-03 11:42:31

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOE J00R

Numéro Job: 42350

Numéro Article: DKC134-00

Numéro Job:



Séq.:

Machine ou Opération:

Description :

44.0

PEINT/PRIMER2

PEINTURE / PRIMER DART



Commentaire Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs
APPLICATION DE PRIMER

Appliquer la deuxième couche de primer Dupont N° 7704S (7975S Activator, 123 S Reducer) Selon I.G. #

Application du primer

18-12-07

3:20 - 3:40



Date: 19-12-07 Heure Début: 11:10 Heure Fin: 11:40 Sceau:



45.0

INSPECTION 3

INSPECTION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
INSPECTION PIÈCE DART

Quantité: 1 Date: 19-12-07 Sceau:



h.s.

Quantité: Date: Sceau:

46.0

EMBALLAGE

EMBALLAGE ET ENTREPOSAGE



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
EMBALLAGE ET ENTREPOSAGE

Faire l'emballage des pièces.

Quantité: 1 Date: 19-12-07 Sceau:



Quantité: Date: Sceau:

Date: Lundi, 2007-12-17 14:30:58
 Opérateur: Marc Dubé

Feuille de Procédé

 Client : DART Dart Aerospace Ltd.
 Numéro Job : 42354
 Numéro Soumission : 2611
 Numéro B.A. :
 Cette fois : 2007-12-17 No. B.V. :
 Prsht Rev. : NC
 Prem. fois : -- Type :
 Job précédente :

 Nom Dessin : SPACE OD BODY **SH**
 Numéro Article : DKC13 0061
 Numéro Dessin : D3188
 Projet Numéro : DKC13
 Révision dessin : E
 Matériel : Fibre 7 et Résine 411-350
 Date Dûe : 2007-1 10 Qté: 1 Udm: UNITE

 Écrit par :
 Vérifié & Approuvé par :
 Commentaires : N° de pièce Dart Aerospace : D31883M

Process Sheet Rév.: 00 Création du premier

Produit additionnel

Numéro Job:



Séq.: Machine ou Opération: Description :


1.0 AC0303 Frekote 44NC

 Commentair Qty.: 0.050 UNITE(s)/Unit Total : 0.050 UNITE(s)
 Frekote 44NC

2.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART


 Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
 PRÉPARATION DU MOULE

Faire la préparation du moule N° DT 8003 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon le QSI-006.

 Date: 14/12/07 Heure Début: 8:30 Heure Fin: 9:30 Sceau: 

3.0 AC0409 Tissu à délaminer Release ply B

 Commentair Qty.: 9.84 VERGE(s)/Unit Total : 9.84 VERGE(s)
 Tissu à délaminer Release ply B

4.0 AC0407 Wrightlon 5200 Bleu P3

 Commentair Qty.: 9.27 VERGE(s)/Unit Total : 9.27 VERGE(s)
 Wrightlon 5200 Bleu P3

5.0 AC0408 Feutre de drainage N° Airweave N 10

 Commentair Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)
 Feutre de drainage N° Airweave N 10

6.0 AC0752 Stretchlon 200 poche à vide Vert

 Commentair Qty.: 7.00 VERGE(s)/Unit Total : 7.00 VERGE(s)
 Stretchlon 200 poche à vide Vert

Date: Lundi, 2007-12-17 14:30:58

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY R/H

Numéro Job: 42354

Numéro Article: DKC134-001

Numéro Job:



Séq.: Machine ou Opération: Description :

7.0 AAC0326 9.7 oz Weave "S" glass #FG-778150-125Y Ver n Finish

Commentair Qty.: 11.4 VERGE(s)/Unit Total : 11.4 VERGE(s)

9.7 oz 7781 Weave "S" glass #FG-778150-125Y N° de Lot: 1-6190 2

8.0 AC0098 Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 4.0000 RL(s)/Unit Total : 4.0000 RL(s)

Ruban à gommer jaune #: T/AT-200Y

9.0 AAC0443 Fiberglass 12 oz Unidirectional

Commentair Qty.: 0.80 VERGE(s)/Unit Total : 0.80 VERGE(s)

Fiberglass 12 oz Unidirectional N° de Lot: 1-6258-1

10.0 AAC0633 WR1850 ROVING 18 OZ x 50"

Commentair Qty.: 0.35 VERGE(s)/Unit Total : 0.35 VERGE(s)

WR1850 ROVING 18 OZ x 50" N° de Lot: 1-6219-1

11.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs
TAILLAGE DU MATÉRIEL

Tailler le matériel, selon les différents patrons de découpe et les quantités inscrites sur ceux-ci.

À fin d'accélérer le processus de taillage, tailler les plis de 9.7 oz tous en même temps en les superposants les uns sur les autres.

Date: 14-12-07 Heure Début: 9:00 Heure Fin: 12:00 Sceau: 34



12.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0640 PINTE(s)/Unit Total : 0.0640 PINTE(s)

Catalyst N° DDM-9 N° de Lot: 1-6118-3

13.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 2.000 KILOGRAMME(s)/Unit Total : 2.000 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-6434-1

14.0 AAC0673 Fibre de verre Miapoxy 66

Commentair Qty.: 0.0039 GALLON(s)/Unit Total : 0.0039 GALLON(s)

Fibre de verre Miapoxy 66

N° de Lot: 1-5951-1

15.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 2% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: Lundi, 2007-12-17 14:30:58

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD ODY R/H

Numéro Job: 42354

Numéro Article: DKC134-006

Numéro Job:



Séq.: Machine ou Opération: Description :

Préparer une seringue remplie de 30 ml de résine chargée de fibre de verre Miapo 66.

Date: 14-12-07 Heure Début: 13:25 Heure Fin: 13:30 Sceau: DELASTEK COMPOSITE 34

16.0

LAMINAGE.

LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs

FAIRE LE LAMINAGE DES TISSUS

À l'aide de la seringue faire un joint tout autour de la dénivellation pour la porte directement dans le moule.

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8003 et ensuite imbiber un pli de tissu 9.7oz. et un 18 oz. sur la section supérieur de la pièces.

Laminage du 12 oz.

Recommencer l'opération pour le deuxième pli.

Date: 14-12-07 Heure Début: 13:30 Heure Fin: 14:30 Sceau: DELASTEK COMPOSITE 23

17.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

FAIRE LA POCHE À VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer
- 2- Film Perforé P-3
- 3- Feutre de drainage
- 4- Sac à vide Stretcglon 200

Laisser sécher pendant 4 heures Minimum.

Date: 14-12-07 Heure Début: 14:30 Heure fin: 14:45 Sceau: DELASTEK COMPOSITE 23



Curing Début: 13:30 Curing Fin: 16:30

18.0

AAC0457

ATC core-cell A500 plain 4'x8' 1" thick

Commentair Qty.: 0.75 FEUILLE(s)/Unit Total: 0.75 FEUILLE(s)

ATC core-cell A500 plain 4'x8' 1" thick Selon dessin D3188 de Dart

N° de Lot: 3-5915-2

Date: Lundi, 2007-12-17 14:30:58

Utilisateur: Marc Dubé

Feuille de Procédé

Cltent: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOL BODY R/H

Numéro Job: 42354

Numéro Article: DKC134-00

Numéro Job:



Séq.: Machine ou Opération: Description :

19.0 FAB GÉNÉRALE 3 FABRICATION GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 120.0000Min Total Run : 2.0000Hrs
TAILLAGE DU MATÉRIEL

Tailler le Foam Core 1" selon le plan de découpe et gabarits

Date: 14-12-07 Heure Début: 14:45 Heure Fin: 16:15 Sceau:



20.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.200 KILOGRAMME(s)/Unit Total : 0.200 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6434-1

21.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0064 PINTE(s)/Unit Total : 0.0064 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 1-6118-3

22.0 FINITION 3 FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
FINITION PIÈCE DART

Prendre les 2 pièces de 11" x 57" et sceller une grande surface sur chacune d'elle Selon I.G. # Sceller le
Foam Core 14-12-07



23.0 AAC0452 Polybond B46F

Commentair Qty.: 0.010 KIT(s)/Unit Total : 0.010 KIT(s)
Polybond B46F

N° de Lot: 1-6253-1

24.0 FINITION 3 FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
FINITION PIÈCE DART

À l'aide de polybond coller ensemble les deux surfaces scellées

Disposer des poids sur les pièces pour conserver une pression de collage

Laisser sécher pour un minimum de 2 heures.

14-12-07



Date: Lundi, 2007-12-17 14:30:58
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 42354

Nom Dessin: SPACEPO BODY R/H
Numéro Article: DKC134-001

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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25.0	TRIMAGE 3	TRIMAGE COMPOSITES DART
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Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
TRIMAGE COMPOSITES DART

Ajuster chacune des pièces de foam core dans le moule selon le dessin.

26.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.
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Commentaire Qty.: 0.300 KILOGRAMME(s)/Unit Total : 0.300 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6434-1

27.0	AAC0275	Catalyst N° DDM-9
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Commentaire Qty.: 0.0096 PINTE(s)/Unit Total : 0.0096 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 1-6118-3

28.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
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Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
PRÉPARATION DU MATÉRIEL DART

Faire la préparation de la résine selon les quantité requises, mix ration 2% de Catalyst N° DDM-9 par quantité de résine N° 411-350 promu 75 minutes..

29.0	FAB GÉNÉRALE 3	FABRICATION GÉNÉRALE DART
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Commentaire Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs
FABRICATION GÉNÉRALE DART

Retirer les pièces de foam core du moule

Sceller les foam core à l'aide de la résine promu N° 411-350 75 minutes. Selon le # sceller le Foam Core

Laisser sécher pendant 2 heures minimum.

Date: 17-12-07 Sceau:



Signature: C.B. R.C.

30.0	AAC0452	Polybond B46F
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Commentaire Qty.: 0.078 KIT(s)/Unit Total : 0.078 KIT(s)
Polybond B46F N° de Lot: 1-6253-1

Date: Lundi, 2007-12-17 14:30:58

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY R/H

Numéro Job: 42354

Numéro Article: DKC134-00

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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31.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
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Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation du Polybond.

Date: 17-12-07 Heure Début: 8:20 Heure Fin: 8:25 Sceau:

32.0	ASSEMBLAGE 3	ASSEMBLAGE GÉNÉRALE DART
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Commentaire Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs
ASSEMBLAGE GÉNÉRALE DES PIÈCES

Coller les différents pièces de Foam Core dans les Spacepod Body à l'aide du Polybond.

Date: 17-12-07 Heure Début: 8:25 Heure Fin: 8:55 Sceau:



33.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE
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Commentaire Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Feutre de drainage
- 3- Sac à vide Stretchlon 200

Laisser sécher pendant 2 heures minimum.

Retirer le bagging entre 1 heure et 1 heure 1/2 après le mélange de résine afin de retirer le surplus de polybond avant qu'il ne soit complètement polymérisé.

Date: 17-12-07 Heure Début: 8:55 Heure Fin: 9:10 Sceau:



Curing Début: 8:25 Curing Fin: 9:55

34.0	AC0058	Polysoft 1.3 kg # 003012 Sikken
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Commentaire Qty.: 0.100 UNITE(s)/Unit Total : 0.100 UNITE(s)

Polysoft 1.3 kg # 003012 Sikken ADTECH P-17

N° de Lot: MA

Date: •Lundi, 2007-12-17 14:30:58

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPO BODY R/H

Numéro Job: 42354

Numéro Article: DKC134-00

Numéro Job:



Séq.: Machine ou Opération: Description :

35.0 AC0059 Durcisseur Polysoft #004009 Sikkens

Commentaire Qty.: 0.078 UNITE(s)/Unit Total : 0.078 UNITE(s)


Durcisseur Polysoft #004009 Sikkens **ADTECH P-17**

36.0 FINITION 3 FINITION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
FINITION GÉNÉRALE

Corriger les petits défauts de surface de la pièce avec du Sikkens. Pour les plus g s défauts utiliser du polybond.

Date: **17-12-07** Heure Début: **10:15** Heure Fin: **10:50** Sceau: 



37.0 AAC0275 Catalyst N° DDM-9

Commentaire Qty.: 0.0504 PINTE(s)/Unit Total : 0.0504 PINTE(s)

Catalyst N° DDM-9

N° de Lot: **1-6118-3**

38.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentaire Qty.: 1.500 KILOGRAMME(s)/Unit Total : 1.500 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.


N° de Lot: **1-6434-1**

39.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 2% de Catalyst N° DD 4-9 par quantité de résine N° 411-350.

Date: **17-12-07** Heure Début: **10:50** Heure Fin: **10:55** Sceau: 


40.0 LAMINAGE. LAMINAGE PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs
FAIRE LE LAMINAGE DES TISSUS

Laminer deux pli de 9.7 oz 7781 S-Glass partout dans le moule.

Le laminage doit être fait à l'aide de la résine N° 411-350 / 2% DDM-9.

Date: **17-12-07** Heure Début: **10:55** Heure Fin: **12:00** Sceau: 



Date: Lundi, 2007-12-17 14:30:58

Utilisateur: Marc Dubé

Feuille de Procédé

Cliant: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPO BODY R/H

Numéro Job: 42354

Numéro Article: DKC134-00

Numéro Job:



Séq.: Machine ou Opération: Description:

41.0 POCHÉ À VIDE 1 FAIRE LA POCHE À VIDE




Commentaire Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Feutre de drainage
- 3- Feutre de drainage 4mm
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: 17-12-07 Heure Début: 12:00 Heure Fin: 12:15 Sceau: 




Curing Début: 12:50 Curing Fin: 16:00

42.0 DÉMOULAGE 1 DÉMOULAGE PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
DÉMOULAGE DES PIÈCES

Démouler la pièce en se servant de la prise d'air sous le moule en faisant bien attention de ne pas abimer les différentes surfaces de la pièce.

Date: 17-12-07 Heure Début: 16:00 Heure Fin: 16:20 Sceau: 




43.0 TRIMAGE 3 TRIMAGE COMPOSITES DART



Commentaire Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs
TRIMAGE DE FINITION

Percer les 8 trous sur la section supérieur de la pièce ainsi que l'ouverture de la pièce à l'aide du gabarit N° DT5801.

Par l'intérieur, percer les 8 dégagement de $\varnothing .745"$ pour les spacers N° D2213 (Ne pas percer la peau extérieure de la pièce)

Date: 18-12-07 Heure Début: 8:00 Heure Fin: 9:00 Sceau: 

Date: Lundi, 2007-12-17 14:30:58

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY R/H

Numéro Job: 42354

Numéro Article: DKC134-0061

Numéro Job:



Séq.: Machine ou Opération: Description :

44.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0048 PINTE(s)/Unit Total : 0.0048 PINTE(s)
Catalyst N° DDM-9N° de Lot: 1-6118-3

45.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.150 KILOGRAMME(s)/Unit Total : 0.150 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.N° de Lot: 1-6452-2

46.0 AAC0673 Fibre de verre Miapoxy 66

Commentair Qty.: 0.0420 GALLON(s)/Unit Total : 0.0420 GALLON(s)
Fibre de verre Miapoxy 66- 3 M K-20N° de Lot: N/A

47.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIELFaire la préparation de la résine selon les quantité requises, mix ration 2% de Catalyst N° DDM-9 par
quantité de résine N° 411-350.Date: 18-12-07 Heure Début: 9:05 Heure Fin: 9:10 Sceau:

48.0 AAC0448 Spacer N° D2213

Commentair Qty.: 8 UNITE(s)/Unit Total : 8 UNITE(s)
Spacer N° D2213 N° de Lot: 1-6441-1

49.0 ASSEMBLAGE 3 ASSEMBLAGE GÉNÉRALE DART

Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs
ASSEMBLAGE GÉNÉRALE DES PIECESFaire l'assemblage des inserts (Spacer) N° D2213 dans les trous prévus à cet effet à l'aide de résine N°
411-350 chargé à l'aide de Fibre de verre Miapoxy 66.

Laminer une pièce de 9 oz. sur chacune des deux zones de 4 spacers pour reboucher les trous.

Appliquer une pression sur les pièces de 9 oz. à l'aide d'un bloc de bois et de pinces autobloquantes.

Laisser sécher pendant 4 heures minimum.

Date: 18-12-07 Heure Début: 9:10 Heure Fin: 9:40 Sceau:

Date: Lundi, 2007-12-17 14:30:58

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY R/H

Numéro Job: 42354

Numéro Article: DKC134-0061

Numéro Job:



Séq.:

Machine ou Opération:

Description :

Curing Début: 9:05 Curing Fin: 10:30

50.0

AAC0275

Catalyst N° DDM-9

Commentair Qty.: 0.0096 PINTE(s)/Unit Total : 0.0096 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 1-6118-3

51.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.300 KILOGRAMME(s)/Unit Total : 0.300 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de lot: 1-6452-2

52.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 2% de Catalyst N° DDM-9 par
quantité de résine N° 411-350.

Date: 18-12-07 Heure Début: 9:40 Heure Fin: 9:45 Sceau:

53.0

LAMINAGE.

LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 55.0000Min Total Run : 0.9167Hrs
FAIRE LE LAMINAGE DES TISSUS

Retirer les pinces et les blocs de bois.

Faire le laminage d'un pli de 9.7 oz 7781 S-Glass sur le contour de la pièce. Selon le dessin

Laisser sécher pendant 4 heures minimum.

Date: 18-12-07 Heure Début: 9:45 Heure Fin: 10:40 Sceau:Curing Début: 9:40 Curing Fin: 11:30

54.0

FINITION 3

FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
FINITION PIÈCE DART

Sabler les surfaces de la pièce pour aider à l'adhésion du primer et enlever les imperfections

Percer les 8 trous de spacers afin de les déboucher.

Date: Lundi, 2007-12-17 14:30:59

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY R/H

Numéro Job: 42354

Numéro Article: DKC134-0061

Numéro Job:



Séq.: Machine ou Opération: Description:

55.0 AAC0683 Dupont Primer N° 7704S

Commentair Qty.: 0.5000 UNITE(s)/Unit Total: 0.5000 UNITE(s)
Dupont Primer N° 7704S N° de Lot: 1-6440-1

56.0 AAC0670 Dupont Activation N° 7975S

Commentair Qty.: 1.0000 PINTE(s)/Unit Total: 1.0000 PINTE(s)
Dupont Activation N° 7975S

N° de Lot: 2-6440-2

57.0 AAC0672 Dupont Reducer N° 12375S

Commentair Qty.: 0.1250 GALLON(s)/Unit Total: 0.1250 GALLON(s)
Dupont Reducer N° 12375S

N° de Lot: N/A

58.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run: 0.0000Hrs
PRÉPARATION DU MATÉRIEL DART

Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabriquant.

59.0 PEINT/PRIMER2 PEINTURE / PRIMER DART

Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs
PEINTURE / PRIMER DART

Appliquer une couche de primer Dupont N° 1104S (7975S Activator, 12375S Reducer) selon les instruction du manufacturier et selon I.G. # Application de Primer.

Laisser sécher pendant 3 heures

Date: 18-12-07 Heure Début: ——— Heure Fin: ——— Sceau: G1



60.0 AAC0665 Label N° D0600-143

Commentair Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)
Label N° D0600-143

N° de Lot: N/A



19-12-07-DS

61.0 AAC0501 Résine Mia-Poxy

Commentair Qty.: 0.015 GALLON(s)/Unit Total: 0.015 GALLON(s)
Résine Mia-Poxy N° de Lot: N/A

19-12-07-DS

Date: Lundi, 2007-12-17 14:30:59

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY R/H

Numéro Job: 42354

Numéro Article: DKC134-0061

Numéro Job:



Séq.: Machine ou Opération: Description:

62.0 AAC0502 Durcisseur 95 Pour Résine Mia-Poxy

Commentair Qty.: 0.030 PINTE(s)/Unit Total: 0.030 PINTE(s)

Durcisseur 95 Pour Résine Mia-Poxy N° de Lot: N/A



19-12-07 J.S.

63.0 AAC0444 Surface Veil

Commentair Qty.: 1.00 VERGE CAR(s)/Unit Total: 1.00 VERGE CAR(s)

Surface Veil N° de Lot: N/A



19-12-07 J.S.

64.0 ASSEMBLAGE 3 ASSEMBLAGE GÉNÉRALE DART

Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs
ASSEMBLAGE GÉNÉRALE DART

Coller le label D0600-143 sur le sac pod en plaçant une surface veil eu dessous et par dessus le label à l'aide de résine Mia Pox. Selon I.F. #DKC134-0019-13

Date: _____ Heure début: _____ Heure fin: _____ Sceau: N/A



19-12-07 J.S.

65.0 AC0058 Polysoft 1.3 kg # 003012 Sikkens

Commentair Qty.: 0.100 UNITE(s)/Unit Total: 0.100 UNITE(s)

Polysoft 1.3 kg # 003012 Sikkens

N° de Lot: 1-6284-1

66.0 AC0059 Durcisseur Polysoft #004009 Sikkens

Commentair Qty.: 0.078 UNITE(s)/Unit Total: 0.078 UNITE(s)

Durcisseur Polysoft #004009 Sikkens

67.0 FINITION 3 FINITION PIÈCE DART

Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run: 1.5000Hrs
FINITION GÉNÉRALE

Faire les réparations de finition s'il y a lieu à l'aide de Sikkens

Faire un léger sablage (Grit 220) de toute les surfaces.

Date: 19-12-07 Heure Début: 8:10 Heure Fin: 10:45 Sceau: 61



68.0 AAC0683 Dupont Primer N° 7704S

Commentair Qty.: 0.2500 UNITE(s)/Unit Total: 0.2500 UNITE(s)

Dupont Primer N° 7704S N° de Lot: 1-6440-1

69.0 AAC0670 Dupont Activator N° 7975S

Commentair Qty.: 0.5000 PINTE(s)/Unit Total: 0.5000 PINTE(s)

Dupont Activator N° 7975S N° de Lot: 2-6440-2 activator and Reducer

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Numéro Job: 42354

Nom Dessin: SPACEPOD E ODY R/H

Numéro Article: DKC134-0061

Numéro Job:



Séq.:

Machine ou Opération:

Description :

70.0

AAC0672

Dupont Reducer N° 12375S

Commentair Qty.: 0.0625 GALLON(s)/Unit Total: 0.0625 GALLON(s)
 Dupont Reducer N° 12375S N° de Lot: *MA*

71.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
 PRÉPARATION DU MATÉRIEL

Nettoyages atyl DEC 19 2007

Masquer le label.

DEC 19 2007



Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabricant.

72.0

PEINT/PRIMER2

PEINTURE / PRIMER DART



Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs
 APPLICATION DE PRIMER

Appliquer deux couche de primer Dupont N° 1104S (7975S Activator, 12375S Reducer) selon les instruction du manufacturier, en prenant bien soin d'attendre 10 minutes entre les couches.

Laisser sécher pendant un minimum de 3 heures

DEC 19 2007

Date: *11:05* Heure Début: *11:05* Heure Fin: *11:30* Sceau:

73.0

INSPECTION 3

INSPECTION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
 INSPECTION GÉNÉRALE

Faire l'inspection générale de la pièces selon le dessin par le département de la qualité.

Date: *19-12-07* Sceau: *QA-11* Initiales: *P.S.**Emballage QT 1**19-12-07*